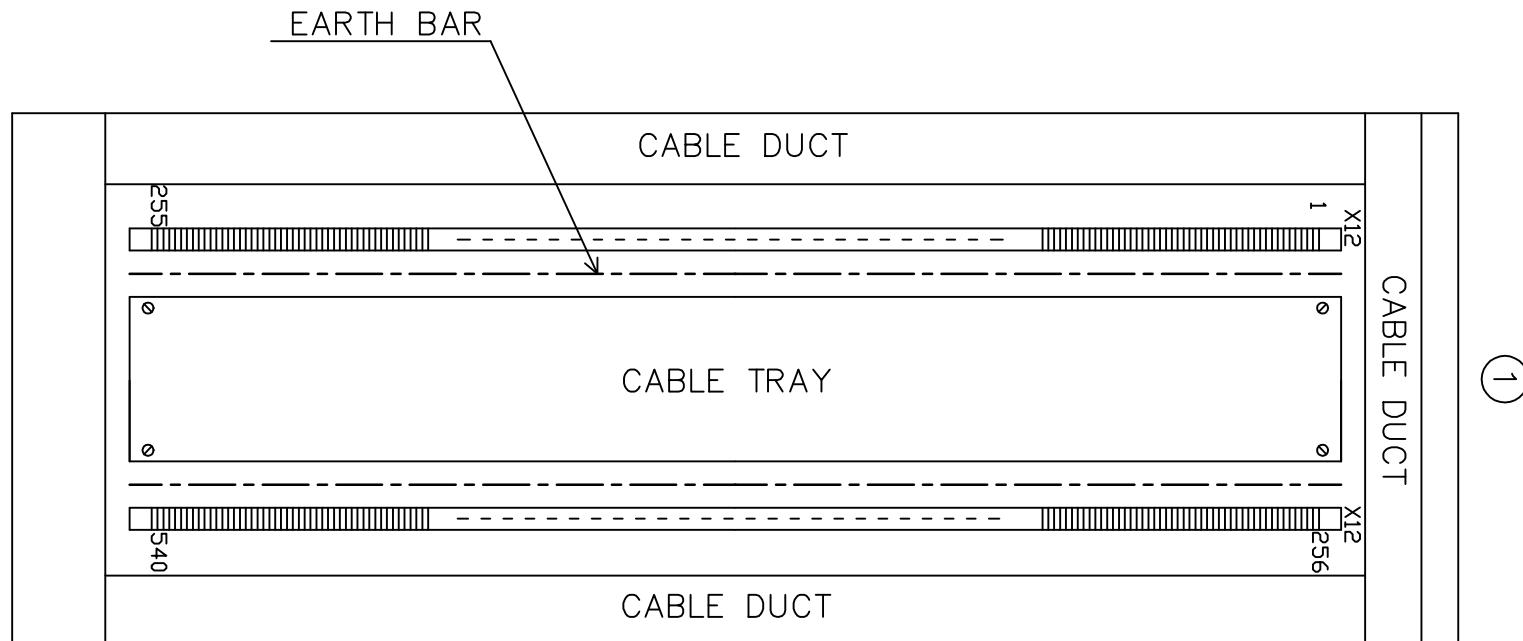


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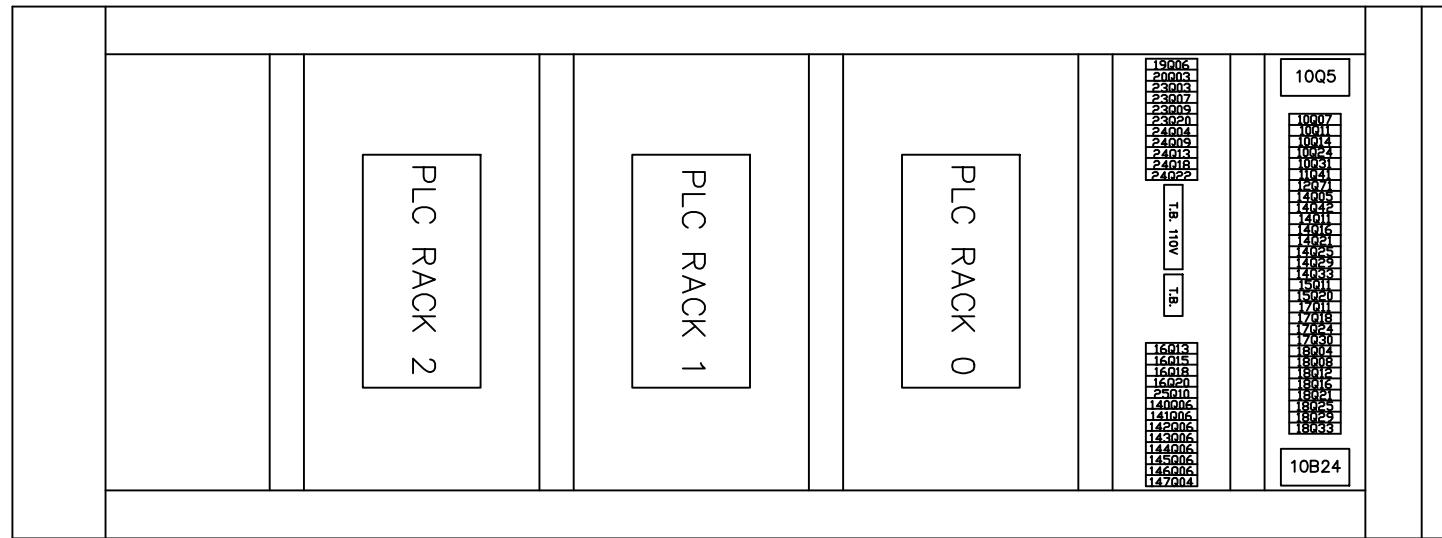


INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL INPUT

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								Total	F12	MATERIAL	
Rufus Huang	JERRY WU			Charlie Z.	05/20/19						

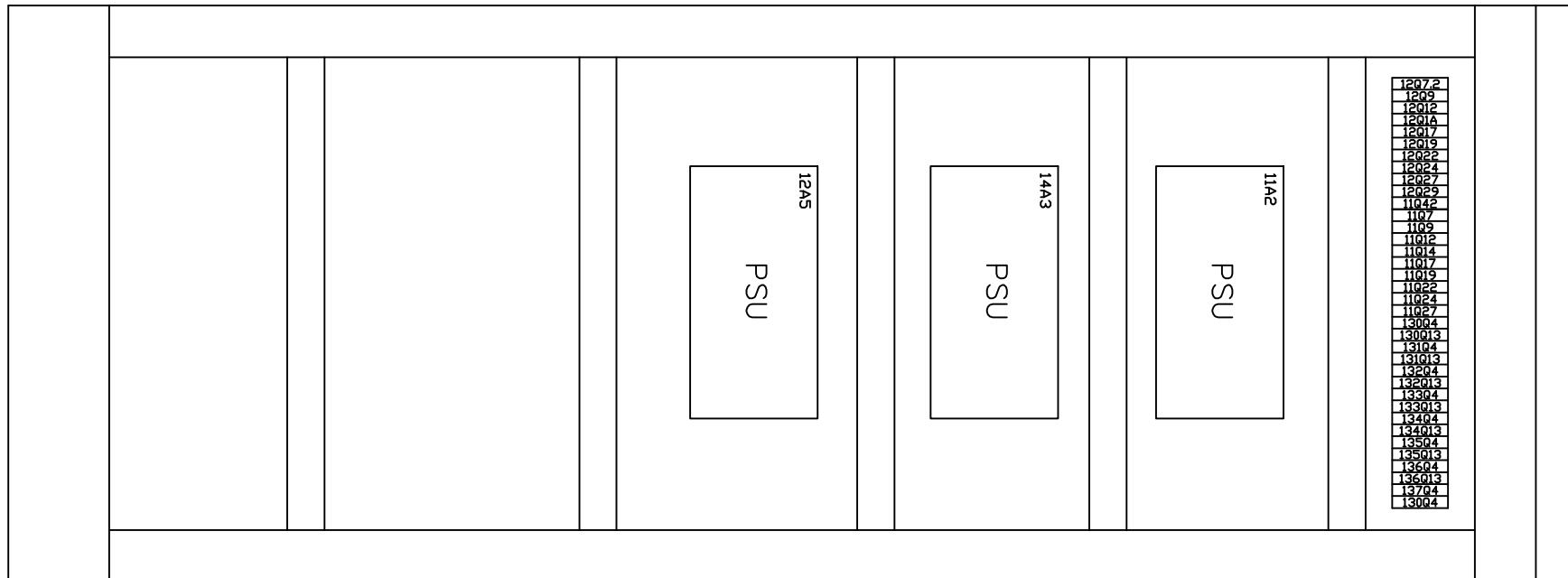
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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.	LINE4 32 P.L.C. DIGITAL INPUT					DRAWING DESCRIPTION	KF023 F12	Page #	2					
										Total					
DRAWN BY	Rufus Huang								MATERIAL						
CHECKED BY	JERRY WU						REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE: 11-27-2012	SCALE	NONE	UNIT	MM

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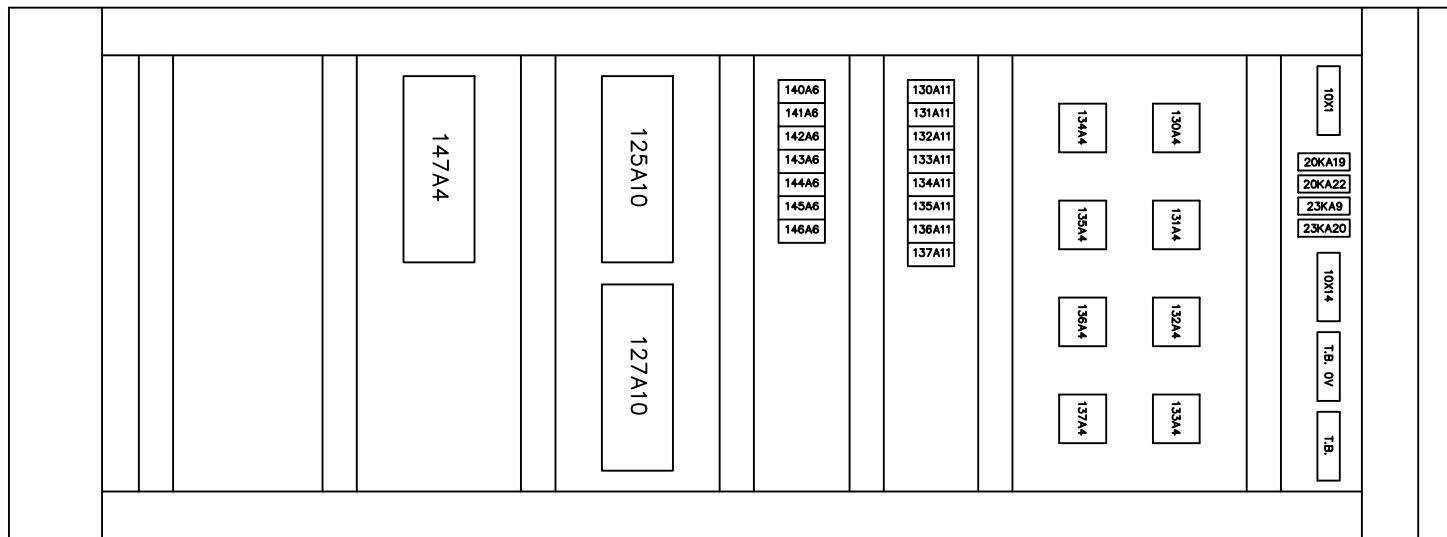


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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.	LINE4 32 P.L.C. DIGITAL INPUT								DRAWING DESCRIPTION	KF023	Page #	3
DRAWN BY	Rufus Huang										F12	Total	
CHECKED BY	JERRY WU	1	Add Terminal Number	Charlie Z.	05/20/19	DRAWING NO.				MATERIAL			
		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	11-27-2012	SCALE	NONE	UNIT	MM		

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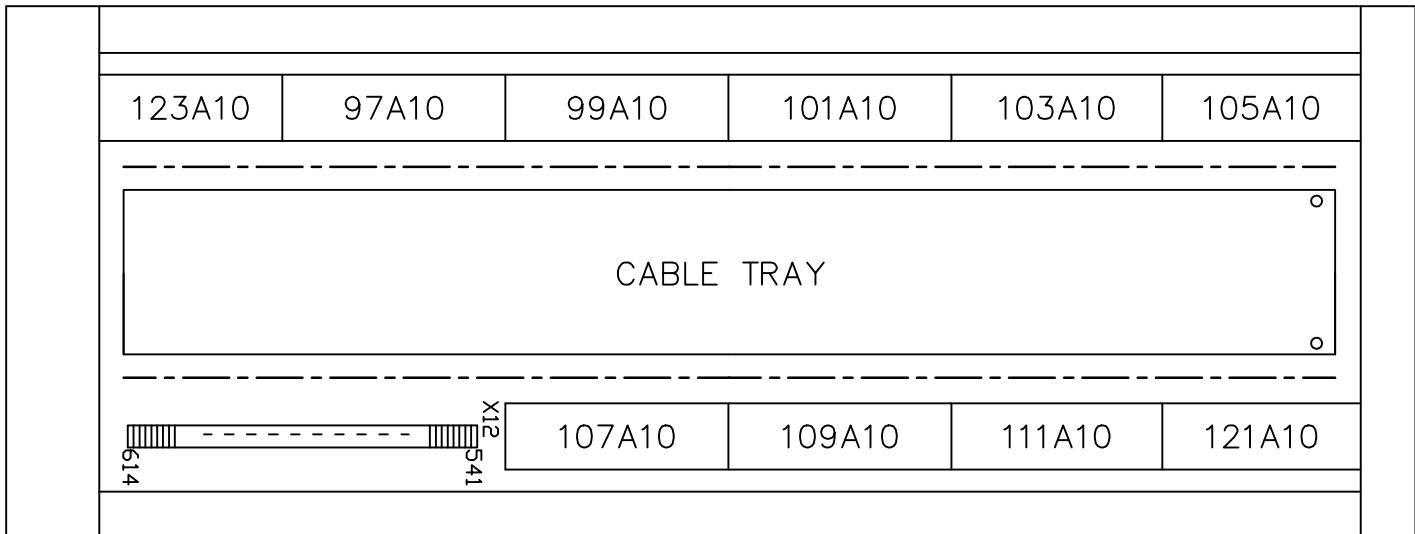


INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

LINE4 32 P.L.C. DIGITAL INPUT

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CHECKED BY	JERRY WU								MATERIAL	
			REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	11-27-2012	SCALE	NONE

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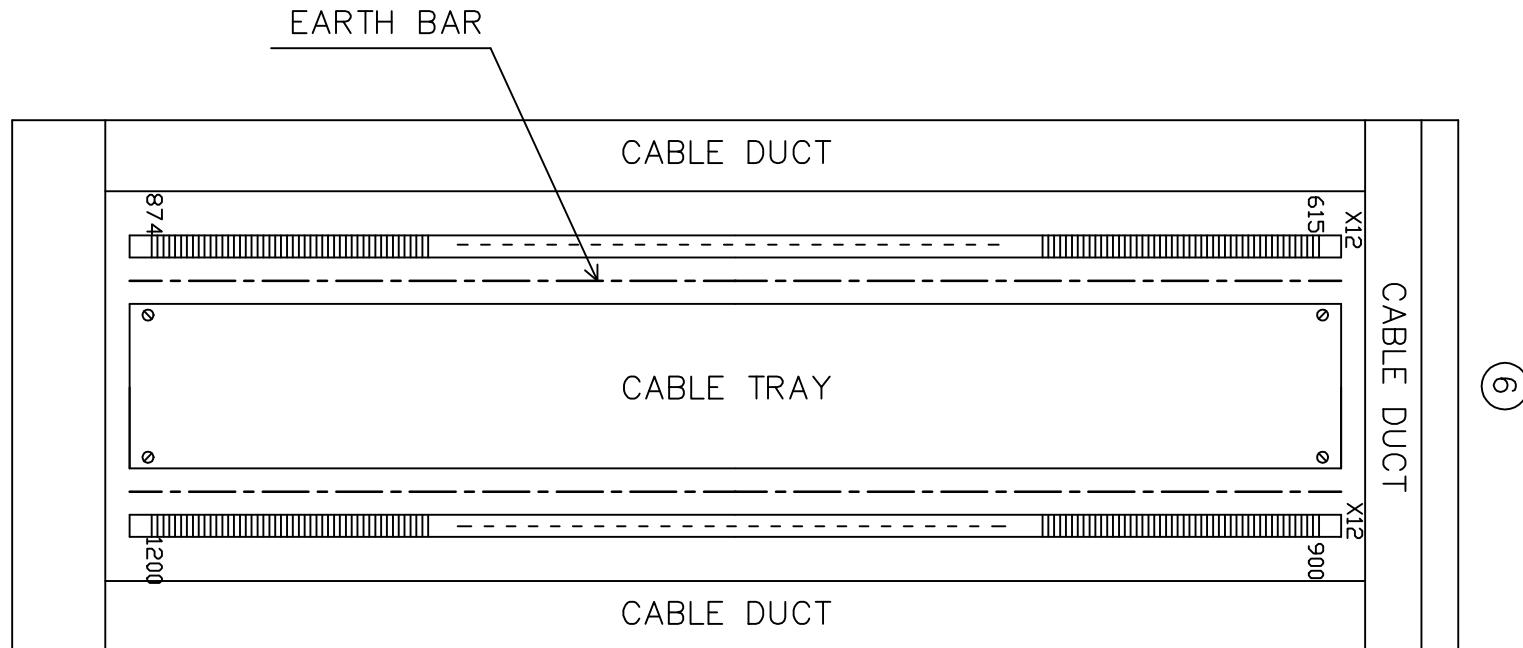


INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

LINE4 32 P.L.C. DIGITAL INPUT

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00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

LINE4 32 P.L.C. DIGITAL INPUT

				DRAWING DESCRIPTION	<u>KF023</u> <u>F12</u>	Page #	6		
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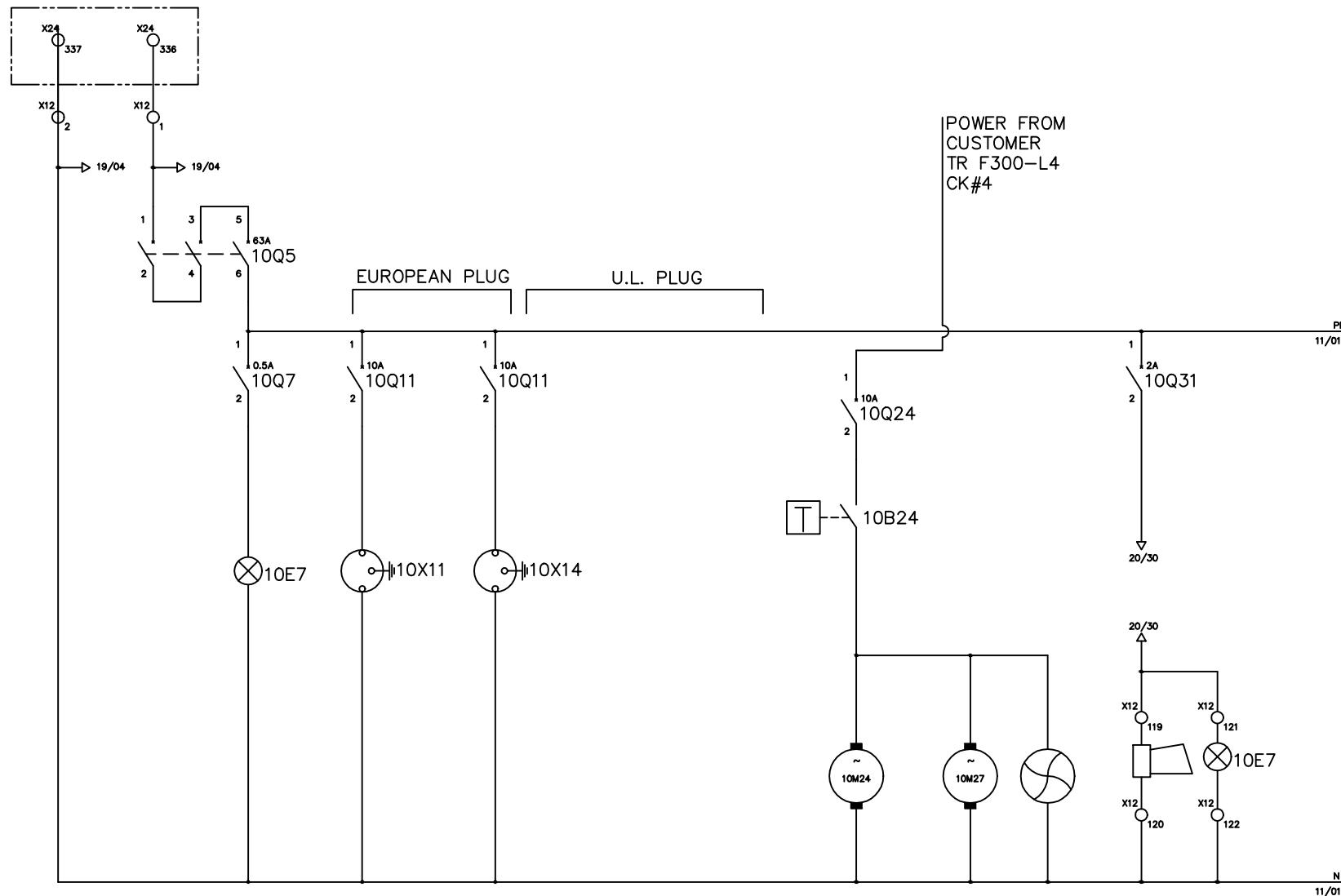
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VOLTAGE ON

PROGRAMMING
UNIT

MONITOR

DOOR FAN5

HORN
EMERG.STOP

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

LINE4 SUPPLY

DRAWN BY Charlie Zhang

CHECKED BY JERRY WU

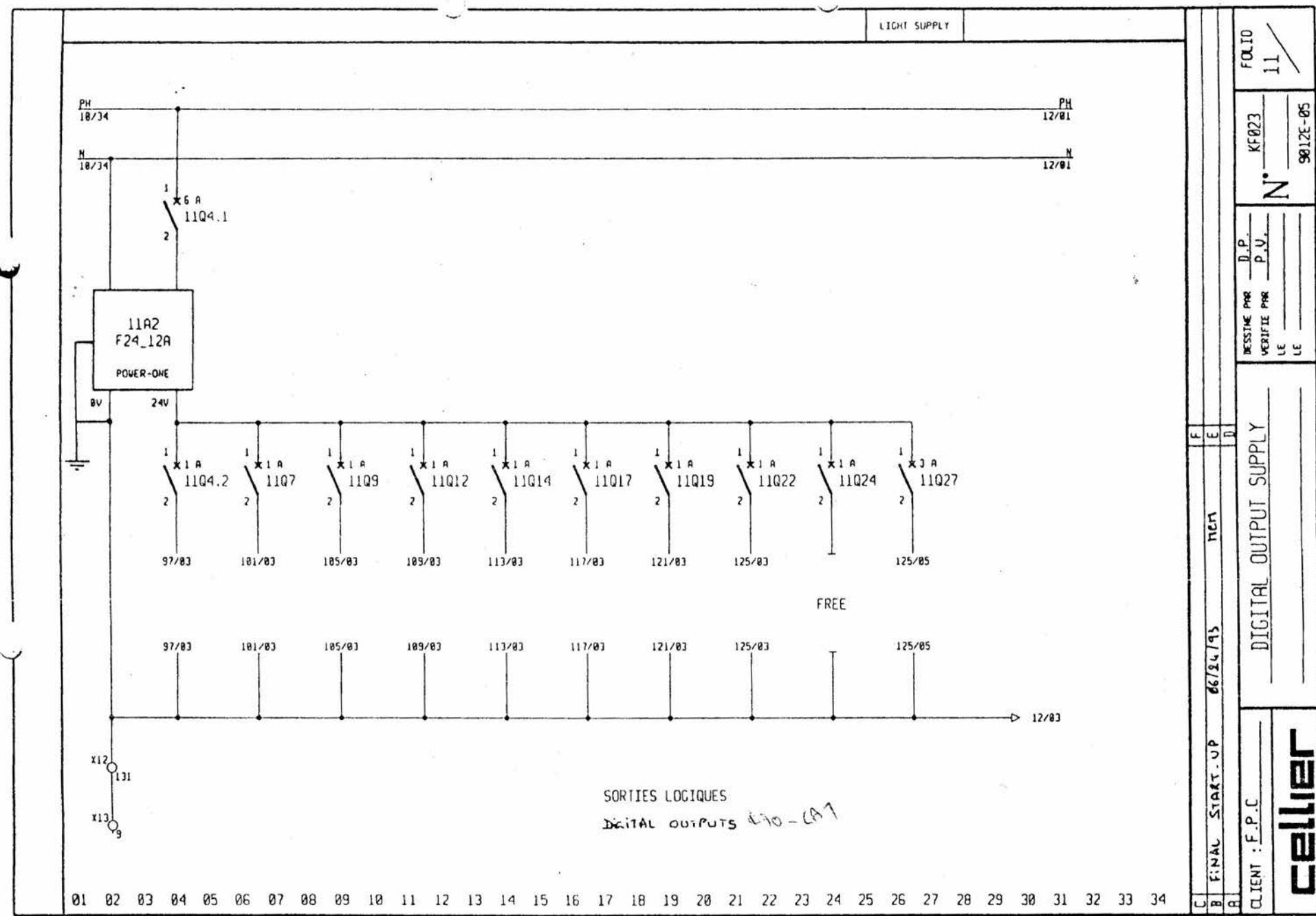
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KF023
F12Page #
10
Total

DRAWING NO.

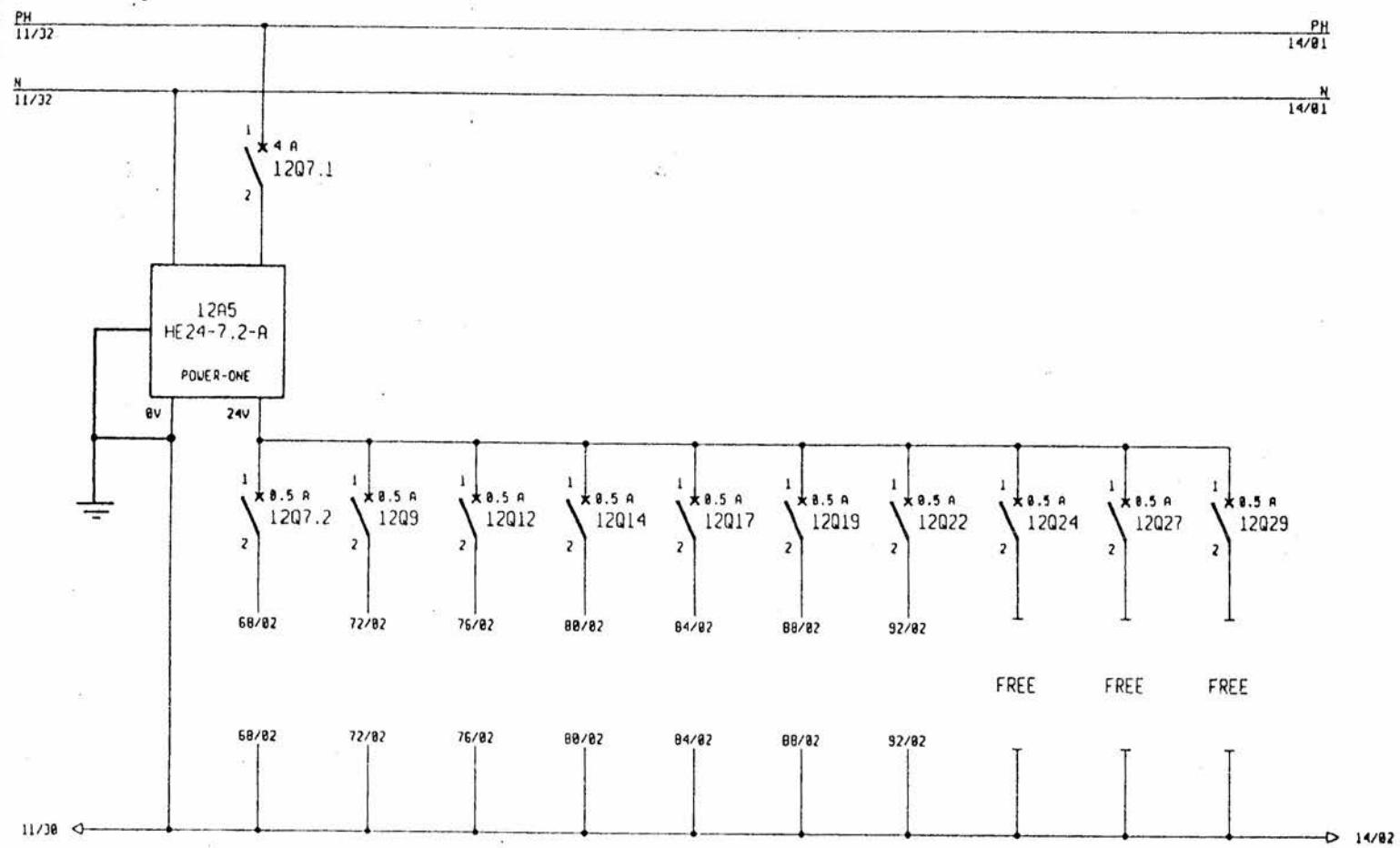
MATERIAL

REV. NO REV. DESCRIPTION REV. BY: REV. DATE DRAWN DATE: 05-23-2019 SCALE NONE UNIT MM

LIGHT SUPPLY



cellier



ENTREES LOGIQUES

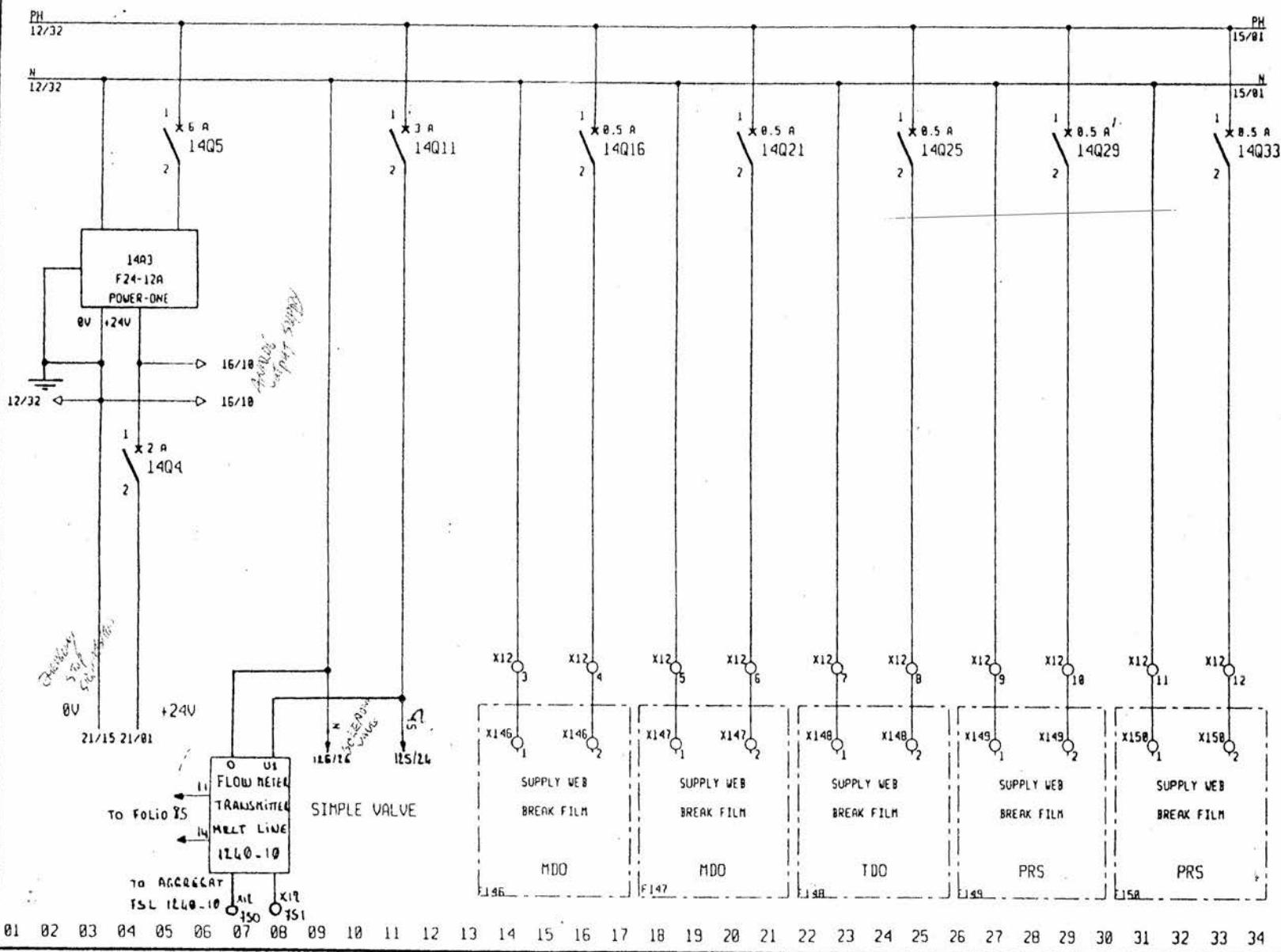
DIGITAL INPUTS C91 - C97

01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34

C	FINAL	START-UP	02/74/93	MCH	F
B				E	
A				D	
DIGITAL INPUT SUPPLY					
CLIENT : F.P.C					
cellier					
FOLIO 12					
N° KF023 N° 9012E-05					

01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34

C	D	E	F	MESSME PAR VERITE PAR	D.P. P.U.	N°	FOLIO
B				LC	LC	KF023	13
A				LC	LC		
CLIENT : F.P.C				FREE			9012E-05
cellier							



FOLIO		14
KF023	N	9015E-05
PRESSURE VERIFY PRESSURE LE LE		
FINAL STATE UP	06/24/93	HCN E D F
SUPPLY		
CLIENT : F.P.C		
celler		

				FOLIO
C				15
B	FINAL STAN. C.P.	06/14/74	HGS	
A	SUPPLY			

cellier

C

CLIENT : F.P.C.

C

FINAL STAN. C.P.

B

06/14/74

A

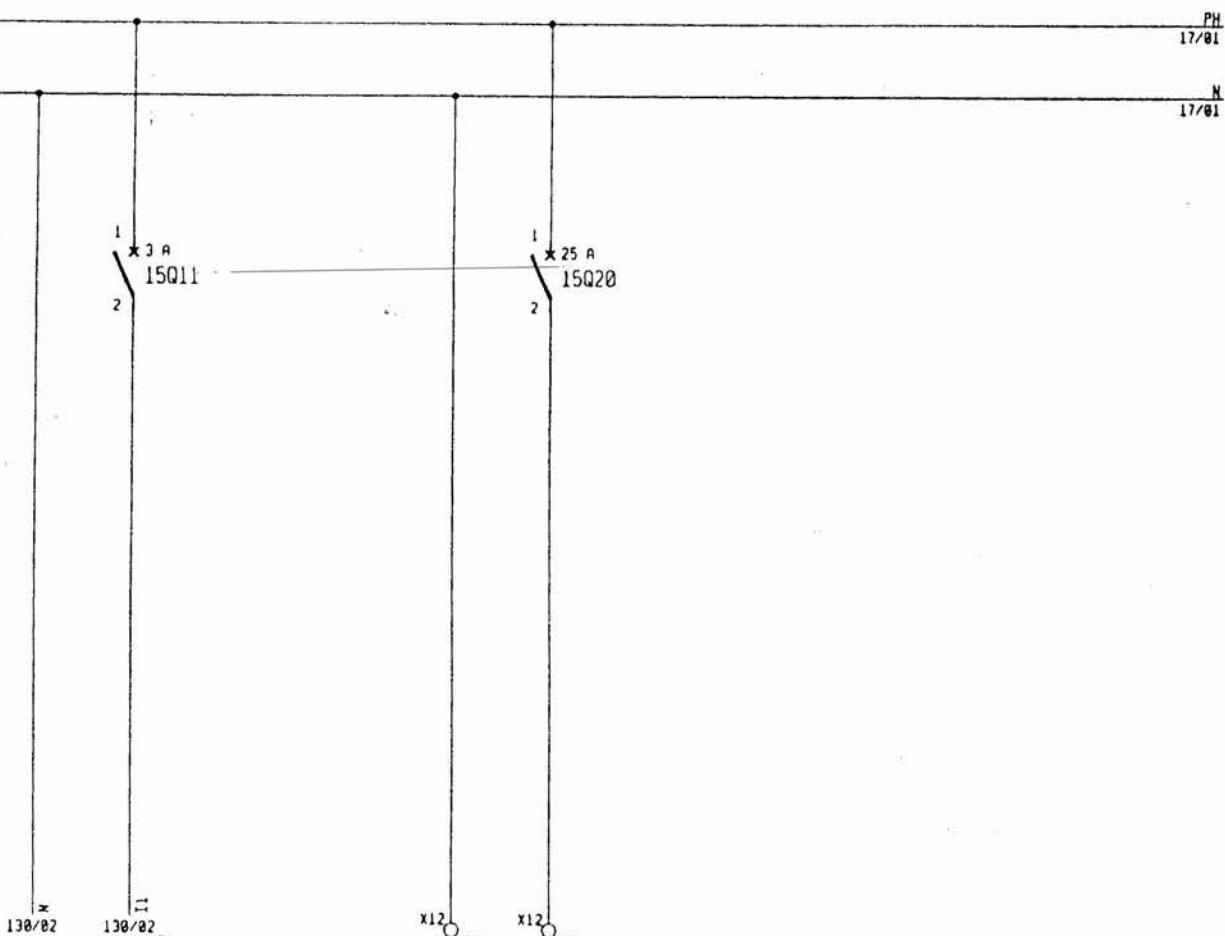
HGS

PH

17/01

N

17/01



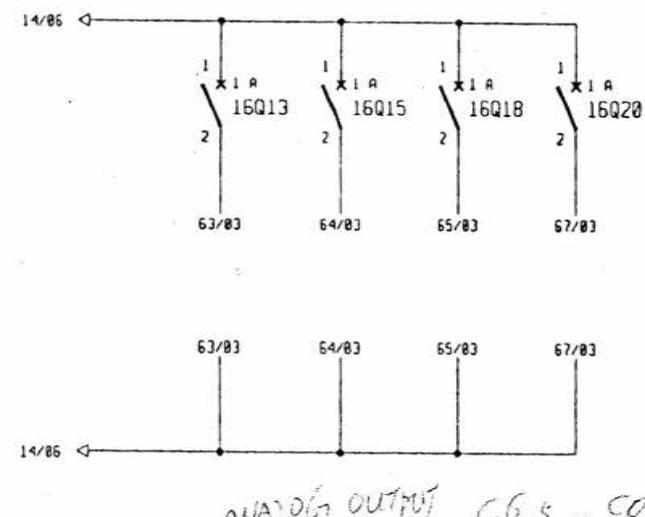
INSTRUMENTATION

TO UPS IN CONTROL ROOM

F 20

01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34

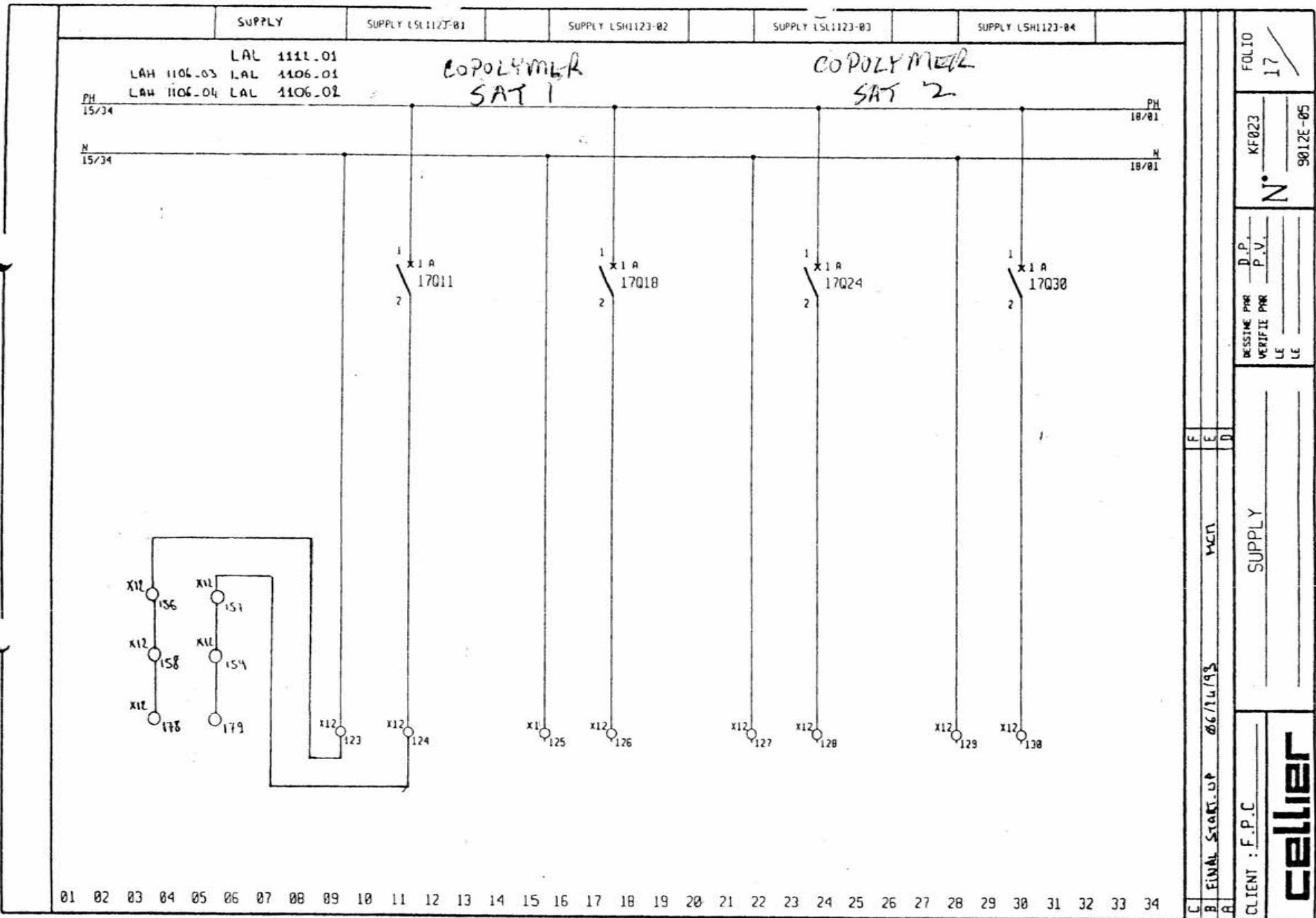
CLIENT : F.P.C	ANALOG OUTPUT SUPPLY	D.P.	Folio
C		P.U.	16
E		LE	/
D		LE	
F			
G			
H			
I			
J			
N°	KF023	9012E-05	



ANALOG OUTPUT C6.5 - C8.0

01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34

cellier



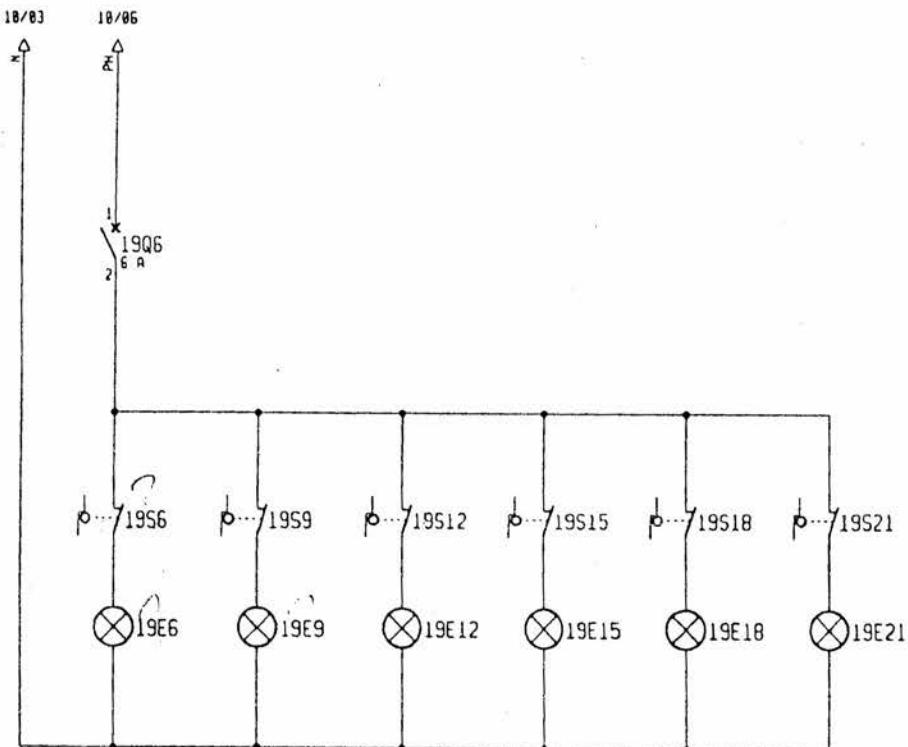
				FOLIO 17
C	E			
B	EFINAL START UP	06/14/93	MCTI	
A	CLIENT : E.P.C	SUPPLY		
	KF023	N°		9012E-05

cellier

SUPPLY LSL1124-01	SUPPLY LSH1124-02	SUPPLY LSL1124-01A	SUPPLY LSH1124-01A	SUPPLY LSL1104-01	SUPPLY LSH1104-02	SUPPLY LSL1104-03	SUPPLY LSH1104-04	
COPOLYMER HOPPER SAT 1	COPOLYMER HOPPER SAT 2	HOMOPOLYMER HOPPER	HOMOPOLYMER HOPPER	HOMOPOLYMER DRYING HOPPER	RECLAIM DRYING HOPPER			
PH 17/34								PH 20/81
N 17/34								N 20/17
1 X1 A 18Q4	1 X1 A 18Q8	1 X1 A 18Q12	1 X1 A 18Q16	1 X1 A 18Q21	1 X1 A 18Q25	1 X1 A 18Q29	1 X1 A 18Q33	
2	2	2	2	2	2	2	2	
X12 O13	X12 O14	X12 O15	X12 O16	X12 O17	X12 O18	X12 O19	X12 O20	
X12 O21	X12 O22	X12 O23	X12 O24	X12 O25	X12 O26	X12 O27	X12 O28	
01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34								

C	D.P.	FOLIO
B FINAL STAKES UP	P.V.	18
A 16/16/93		
C VIDEO SUPPLY		
CLIENT : F.P.C		
cellier		
KF023	N°	3012E-05

LIGHTING BOARD



01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34

cellier

CLIENT : F.P.C.

C B A

LIGHTING BOARD

9812E-05

FOLIO

19

N°

KF023

D.P.

P.V.

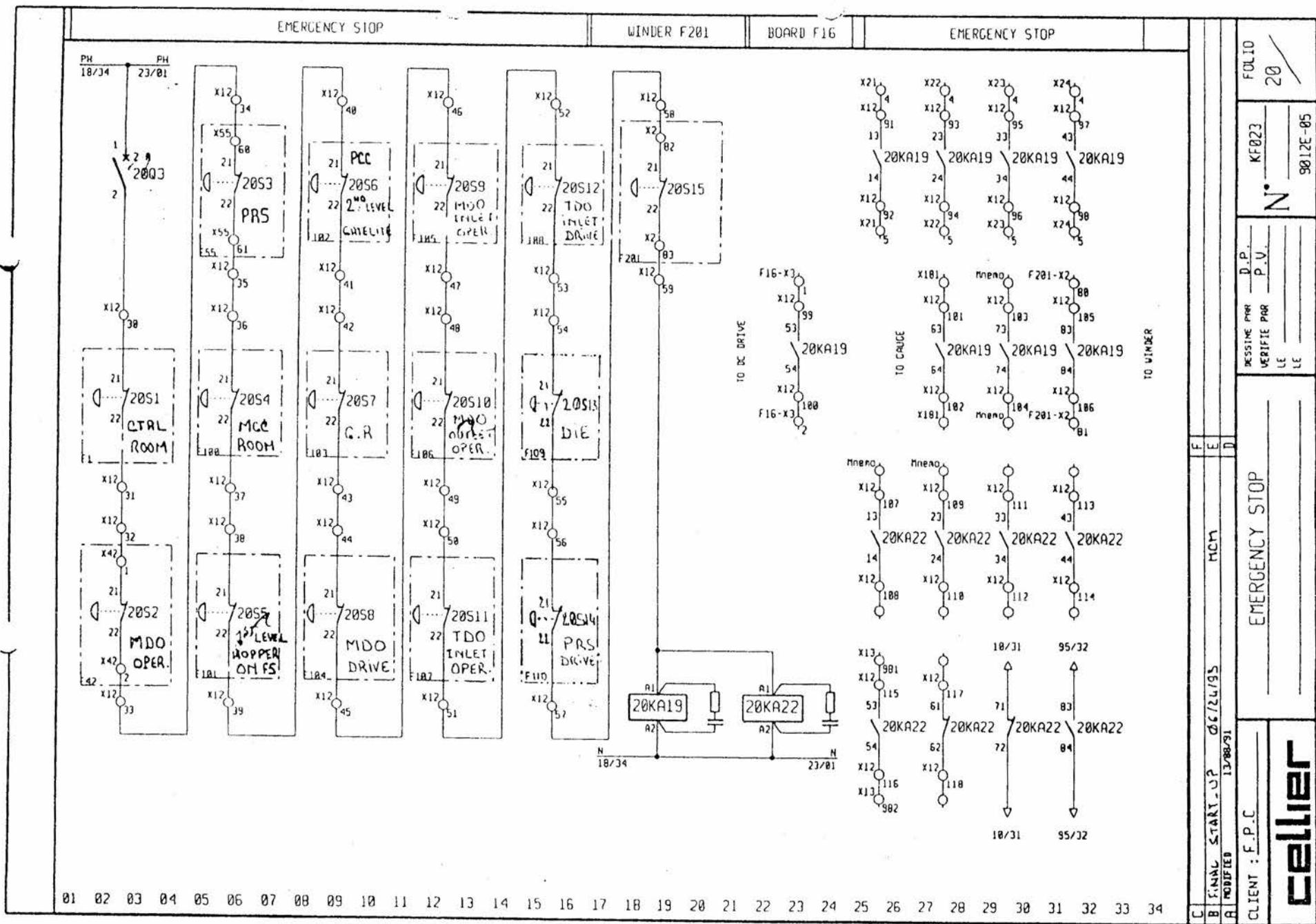
LE

LE

D

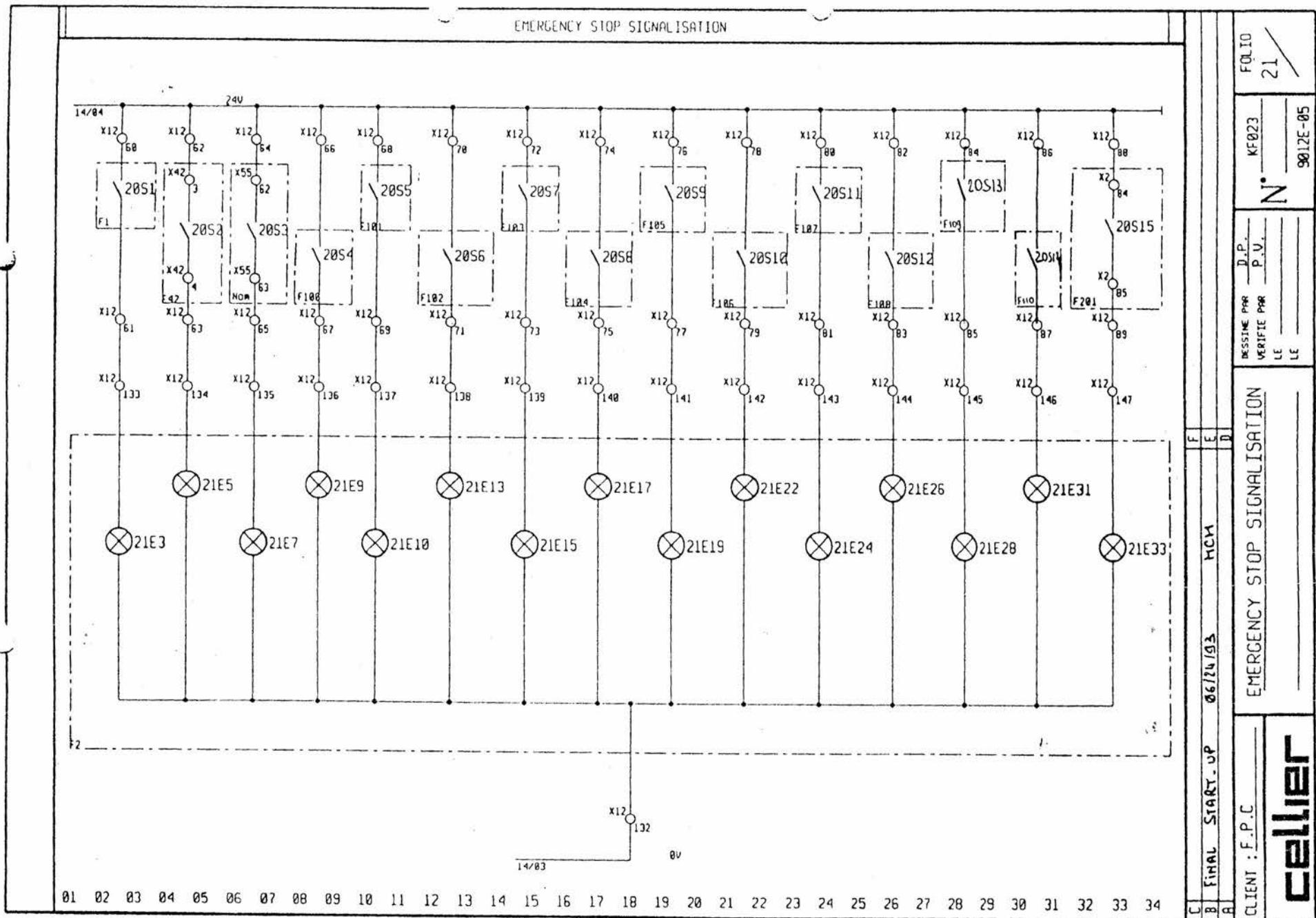
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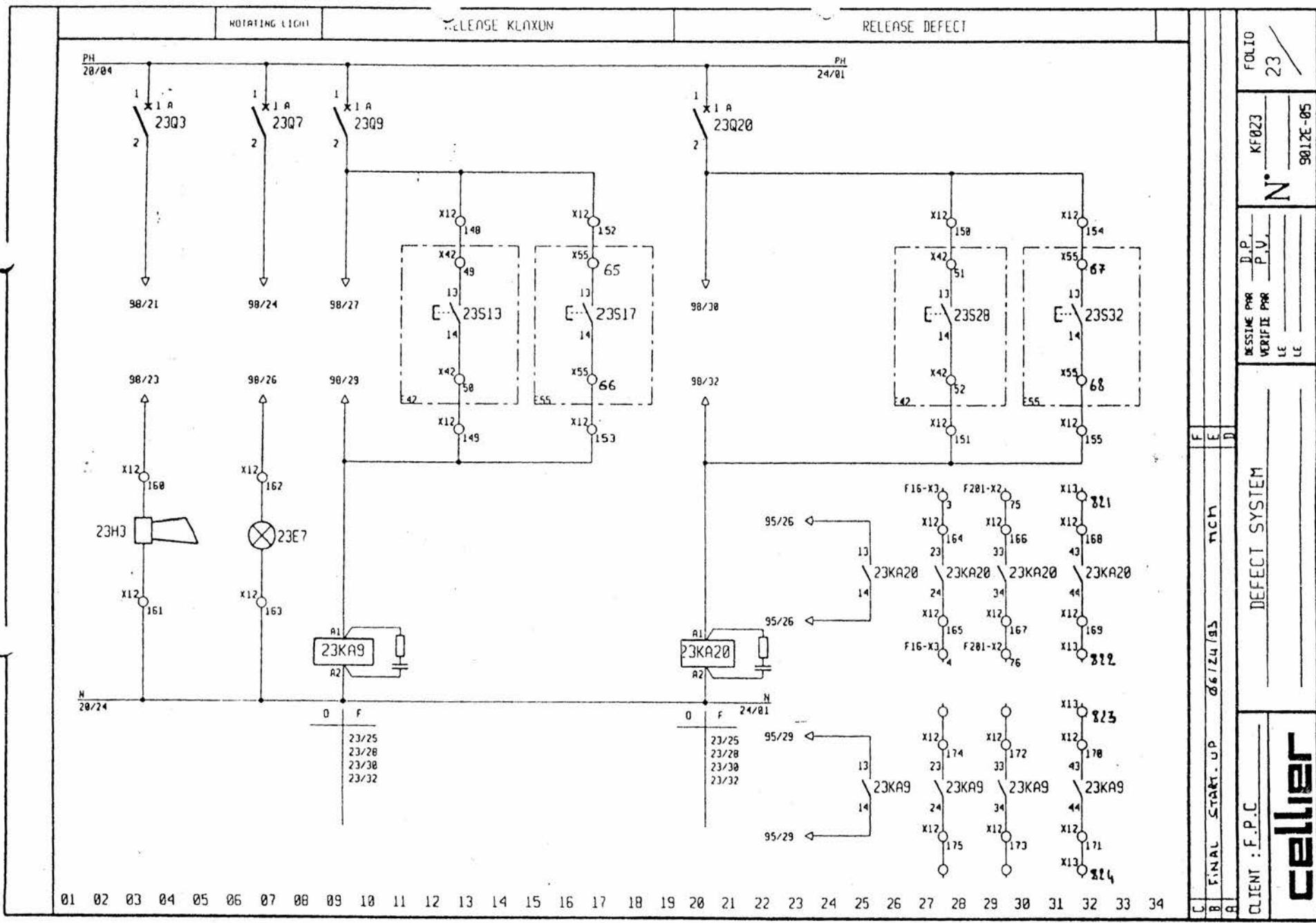
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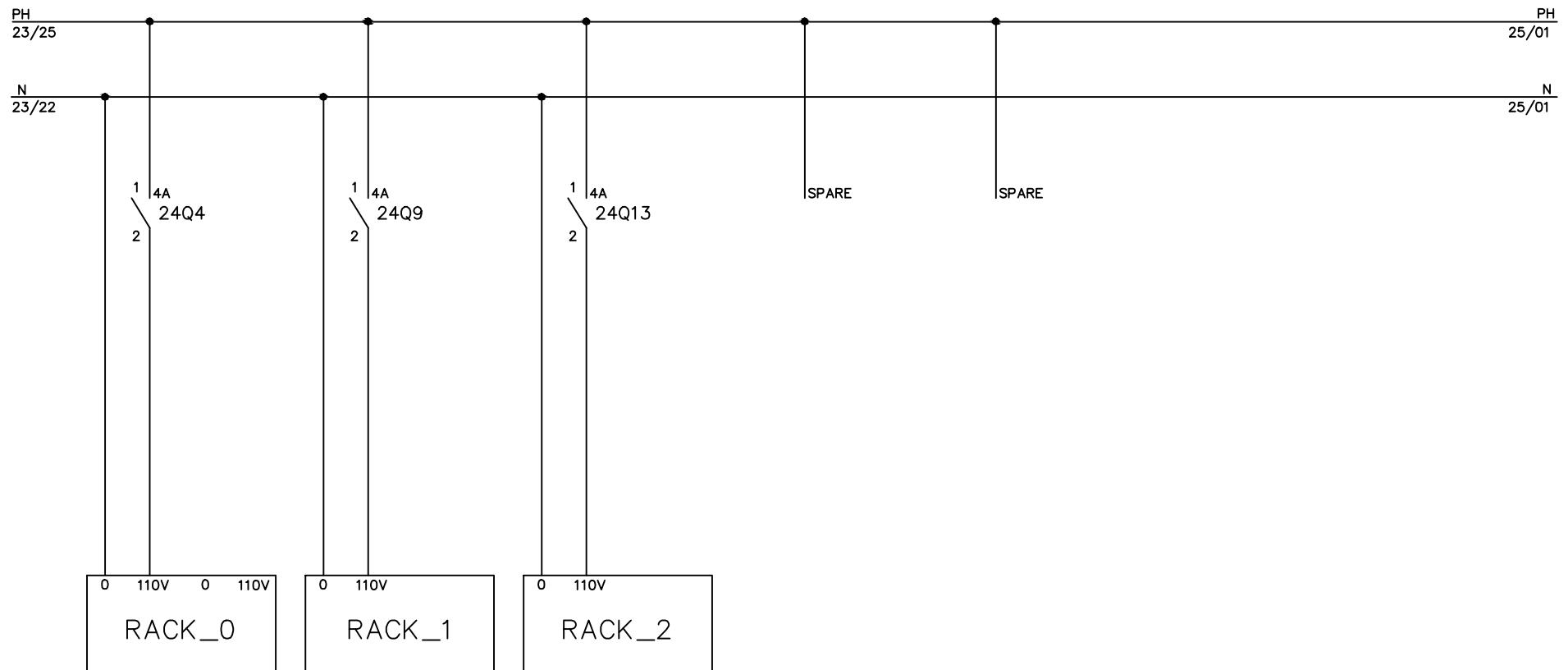
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B	START-UP	06/24/95	HIGH
A	MOTORIZED	12/08/91	
	EMERGENCY STOP		
C	F.P.C.		
B	VERIFIED		
A	VERIFIED		
	cellier		

EMERGENCY STOP SIGNALISATION





01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
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File Name : P24 PLC Supply.dwg

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DRAWN BY	LINE4 P.L.C SUPPLY																				F12		Total										
CHECKED BY	JERRY WU																				MATERIAL												
																					REV. NO		REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM		

PH
24/34

N
24/34

25Q10
4A

25510

A1
25KA10
A2

A1
25KA14
A2

A1
25KA17
A2

A1
25KA21
A2

A1
25KA25
A2

A1
25KA29
A2

01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34

C B A

cellier

CLIENT : F.P.C

FQ10
25

KF023
9012E-05

N

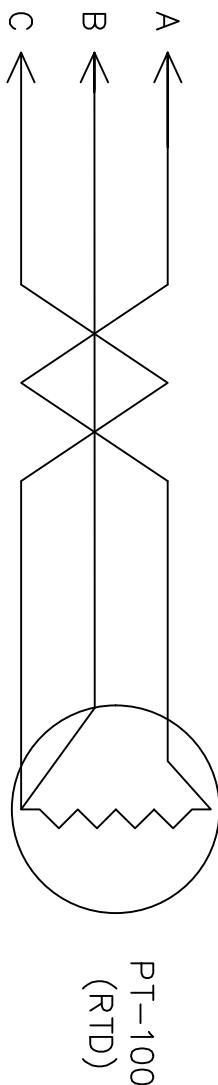
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E

D

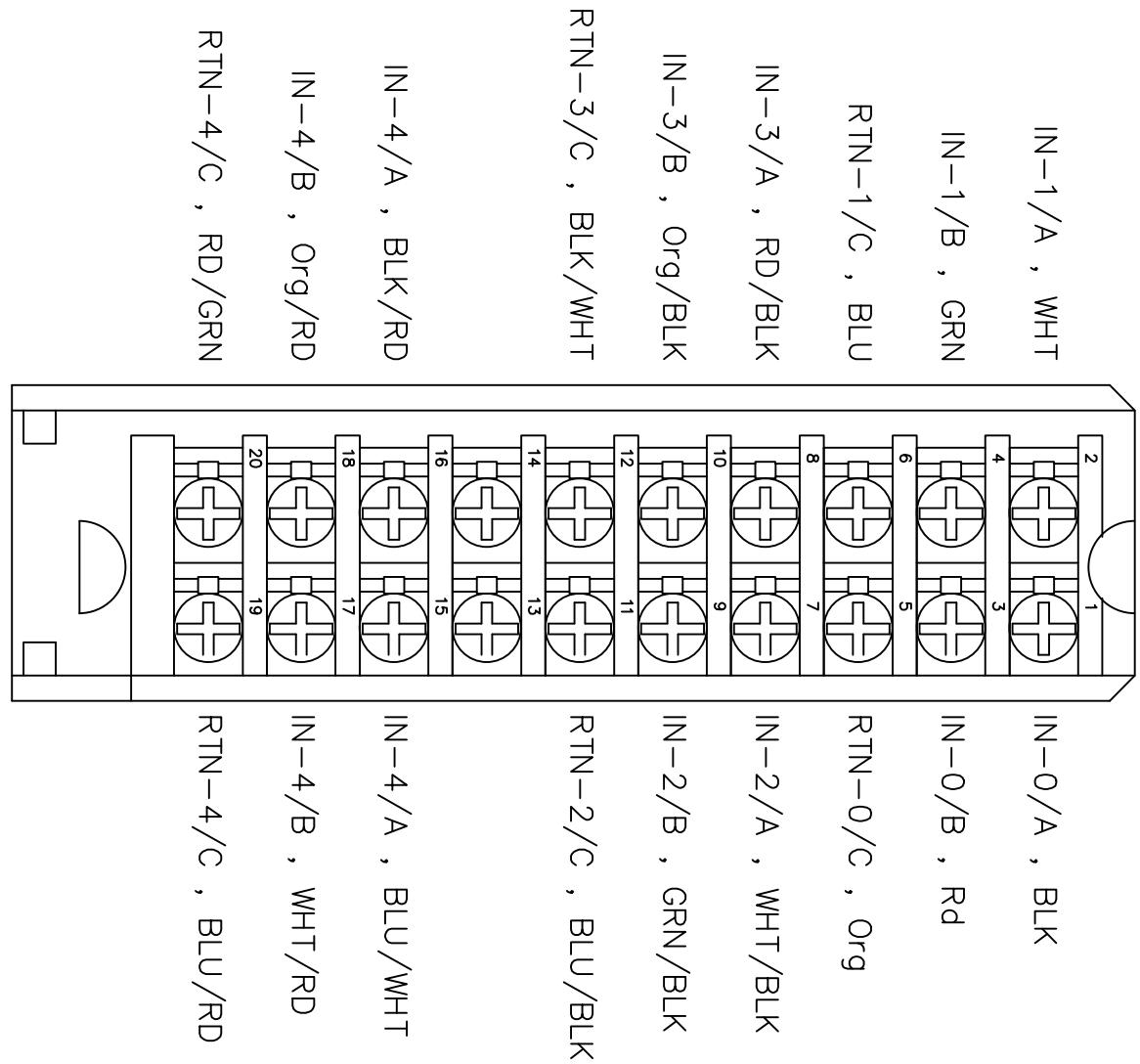
DOOR LOCKED

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CHO :	1	, 3	, 5	CH3 :	8	, 10	, 12
CH1 :	2	, 4	, 6	CH4 :	15	, 17	, 19
CH2 :	7	, 9	, 11	CH6 :	16	, 18	, 20

1756-IR61 Module wiring



File Name: P25 1756-IR61 wirings.dwg

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DRAWN BY	Charlie Zhang																									F12	Total						
CHECKED BY	JERRY WU																											MATERIAL					

Line4 1756-IR61 3-wire RTD wiring

REV. NO REV. DESCRIPTION REV. BY: REV. DATE DRAWN DATE: 05-23-2019 SCALE NONE UNIT MM

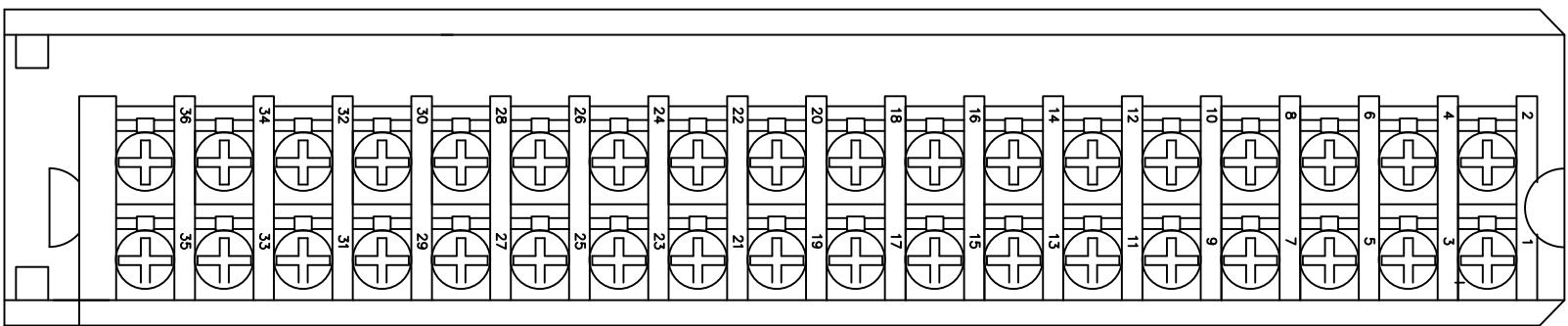
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CHO : 2 , 4&1
CH1 : 6 , 8&5
CH2 : 12 , 14&11
CH3 : 16 , 18&15

CH4 : 20 , 22&19
CH5 : 24 , 26&23
CH6 : 30 , 32&29
CH7 : 34 , 36&33

1756-IF16 Different current Wiring

& Mean jumper wires



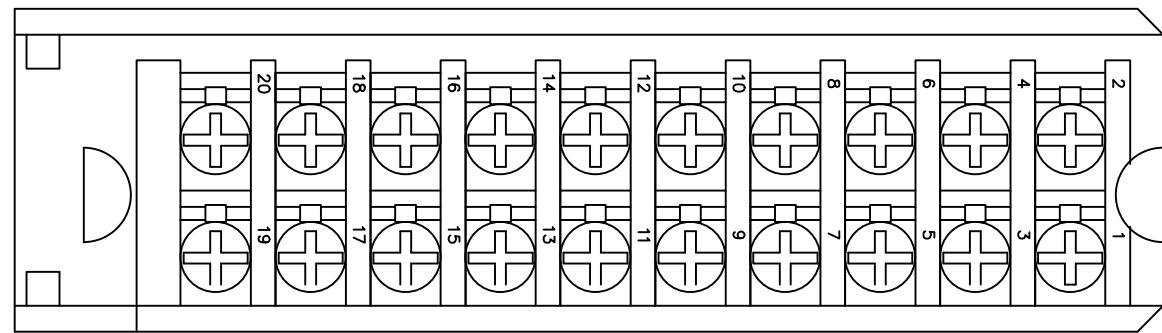
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Line4 1756-IF16 Different current Wiring																DRAWING DESCRIPTION	KF203 F12	Page #	26														
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

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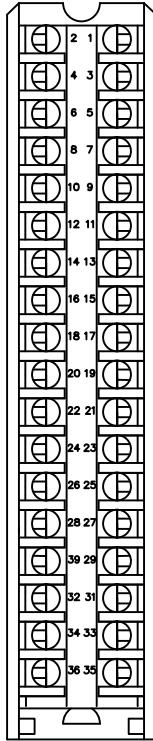


1756-0F4 Current wiring

FILE NAME: P27 1756-0F4 Wirings.dwg

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DRAWN BY	Line4 1756-0F4 Current wiring															DRAWING NO.				Total																	
CHECKED BY	JERRY WU															REV. NO				REV. DESCRIPTION		REV. BY:		REV. DATE		DRAWN DATE:		05-23-2019		SCALE		NONE		UNIT		MM	

WHT , IN-0		1 RTN-0 , BLK
GRN , IN-1		1 RTN-1 , RD
BLU , IN-2		1 RTN-2 , ORG
RD/BLK , IN-3		1 RTN-3 , WHT/BLK
ORG/BLK , RTN	10 9	RTN , GRN/BLK
BLK/WHT , IN-4	12 11	1 RTN-4 , BLU/BLK
GRN/WHT , IN-5	14 13	1 RTN-5 , RD/WHT
BLK/RD , IN-6	16 15	1 RTN-6 , BLU/WHT
ORG/RD , IN-7	18 17	1 RTN-7 , WHT/RD
RD/GRN , IN-8	20 19	1 RTN-8 , BLU/RD
BLK/WHT-RD , IN-9	22 21	1 RTN-9 , ORG/GRN
RD/BLK-WHT , IN-10	24 23	1 RTN-10 , WHT/BLK-RD
ORG/BLK-WHT , IN-11	26 25	1 RTN-11 , GRN/BLK-WHT
BLK/RD-CRN , RTN	28 27	RTN , BLU/BLK-WHT
RD/BLK-GRN , IN-12	30 29	1 RTN-12 , WHT/RD-CRN
ORG/BLK-GRN , IN-13	32 31	1 RTN-13 , GRN/BLK-ORG
BLK/WHT-ORG , IN-14	34 33	1 RTN-14 , BLU/WHT-ORG
ORG/WHT-BLU , IN-15	36 35	1 RTN-15 , WHT/RD-ORG

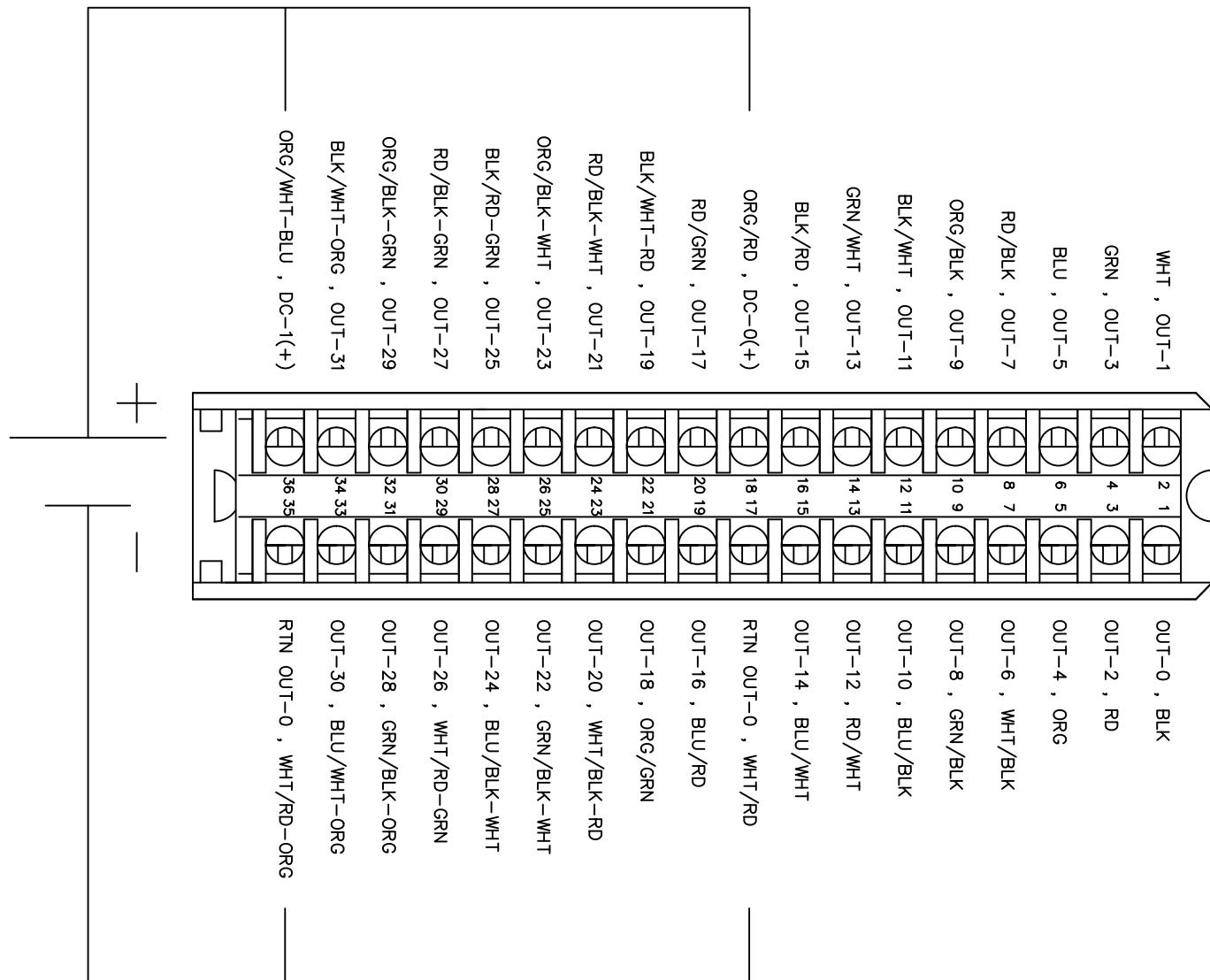


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WHT , IN-1		2 1	1																																	
GRN , IN-3		4 3	1																																	
BLU , IN-5		6 5	1																																	
RD/BLK , IN-7		8 7	1																																	
ORG/BLK , IN-9		10 9	1																																	
BLK/WHT , IN-11		12 11	1																																	
GRN/WHT , IN-13		14 13	1																																	
BLK/RD , IN-15		16 15	1																																	
ORG/RD , GND-0		18 17	1																																	
RD/GRN , IN-17		20 19	1																																	
BLK/WHT-RD , IN-19		22 21	1																																	
RD/BLK-WHT , IN-21		24 23	1																																	
ORG/BLK-WHT , IN-23		26 25	1																																	
BLK/RD-GRN , IN-25		28 27	1																																	
RD/BLK-GRN , IN-27		30 29	1																																	
ORG/BLK-GRN , IN-29		32 31	1																																	
BLK/WHT-ORG , IN-31		34 33	1																																	
GND-1 , WHT/RD-ORG		36 35	1																																	

FILE NAME: P28 1756-IB32 Wiring.dwg
01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34
INTERPLAST GROUP, Ltd.
Autoprop DNA, Inc. & EPIC
Line4 1756-IB32 ControlLogix input
midule
DRAWN BY: Charlie Zhang
CHECKED BY: JERRY WU
REV. NO. REV. DESCRIPTION REV. BY REV. DATE DRAWN DATE 08-23-2010 SCALE 1:1000 UNIT MM
IN-0 , BLK
IN-2 , RD
IN-4 , ORG
IN-6 , WHT/BLK
IN-8 , GRN/BLK
IN-10 , BLU/BLK
IN-12 , RD/WHT
IN-14 , BLU/WHT
IN-16 , BLU/RD
IN-20 , WHT/BLK-RD
IN-22 , GRN/BLK-WHT
IN-24 , BLU/BLK-WHT
IN-26 , WHT/RD-GRN
IN-28 , GRN/BLK-ORG
IN-30 , BLU/WHT-ORG
Total
MATERIAL

1756-IB32 ControlLogix input module

01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34



File Name: P29 1756-IB32 Wirings.dwg



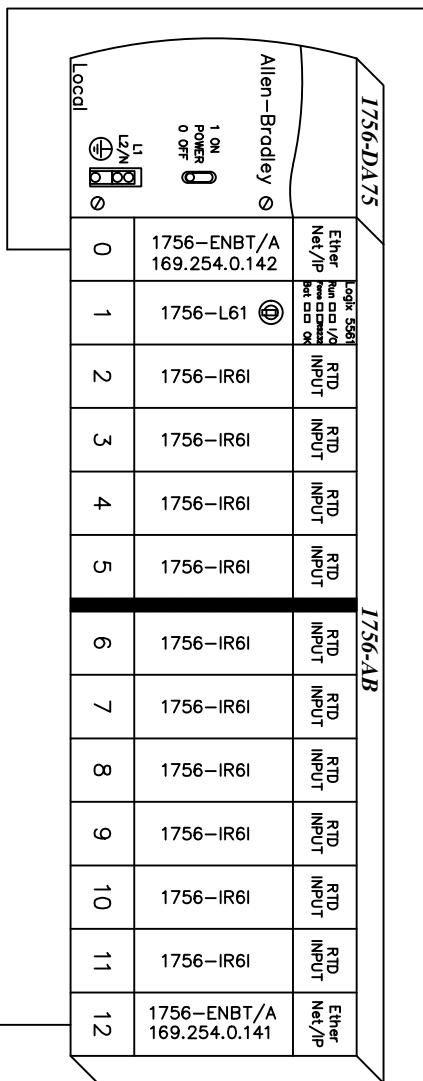
INTEPLAST GROUP, Ltd.
AMTOPP DIVI. M/E DEPT.

Line4 1756-IB32 ControlLogix input module

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 INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.	Line4 1756-IB32 ControlLogix input midule															DRAWING DESCRIPTION	KF203 F12		Page #		29												
DRAWN BY	Charlie Zhang															Total																	
CHECKED BY	JERRY WU															DRAWING NO.	MATERIAL																
											REV. NO	REV. DESCRIPTION		REV. BY:	REV. DATE	DRAWN DATE:	05-23-2019		SCALE	NONE	UNIT	MM											

01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34

RACK 0



LOCAL I/O

REMOTE I/O

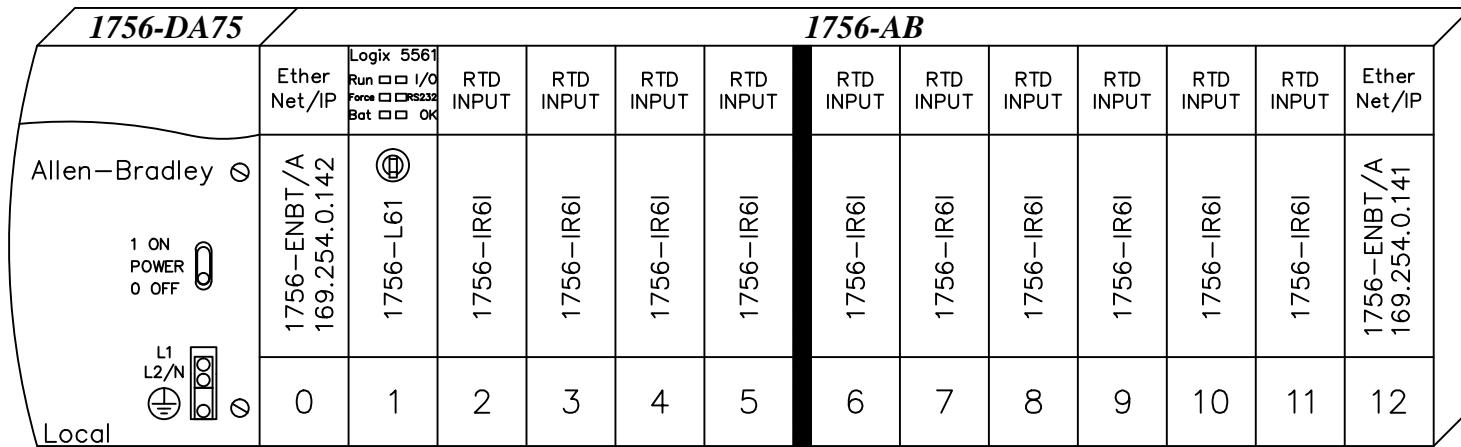
REMOTE I/O

File Name : P30 PLC Module Link Layout.dwg

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	INTEPLAST GROUP, Ltd. AMTOPP DIVI. M/E DEPT.		Line4 PLC MODULE LINK LAYOUT																DRAWING DESCRIPTION		KF023 F12		Page #		30													
DRAWN BY	Charlie Zhang																		DRAWING NO.		Total																	
CHECKED BY	JERRY WU																		REV. NO		REV. DESCRIPTION		REV. BY:		REV. DATE		DRAWN DATE:		05-23-2019		SCALE		NONE		UNIT		MM	

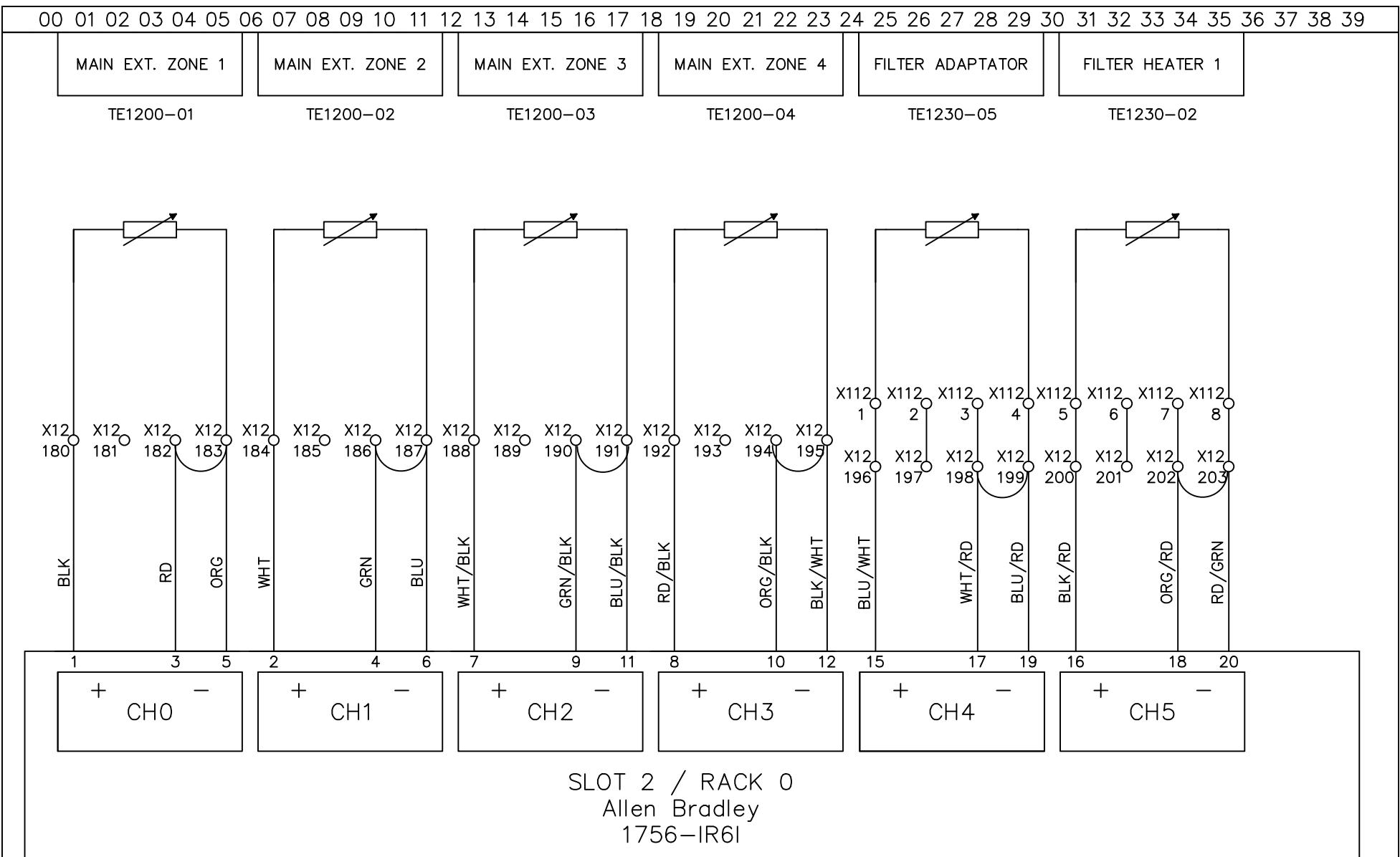
01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34

RACK 0



LOCAL I/O

File Name : P31_Rack0.dwg



IW01_3
W[4760]

IW01_4
W[4763]

IW01_5
W[4766]

IW01_6
W[4769]

IW02_3
W[4772]

IW02_4
W[4775]

File Name : P32-33 slot 2 Allen Bradley 1756-IR6I.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 6 P.L.C. ANALOG INPUT
PT100 Probe °F

DRAWN BY	REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWING NO.	DRAWING DESCRIPTION	Page #	
							Total	
CHECKED BY	JERRY WU						SCALE	NONE

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

FILTER HEATER 3

FILTER HEATER 2

FIRST MELT LINE ZONE
1

FIRST MELT LINE ZONE
2

FIRST MELT LINE ZONE
3

NE FIRST MELT LINE ZONE
4

TE1230-03

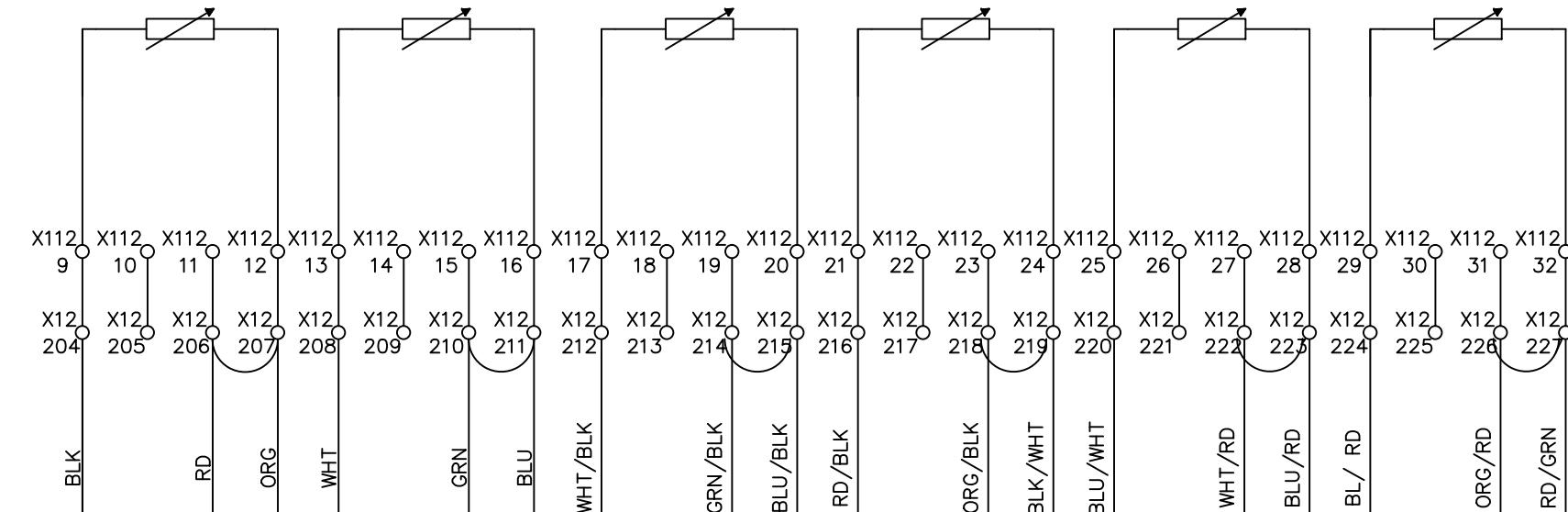
TE1230-04

TE1200-12

TE1200-13

TE1200-14

TE1200-15



$$+ \text{CHO} -$$

+ CH1 -

$$+\text{CH}_2^-$$

$$+ \text{CH}_3 -$$

$$+ \text{CH}_4 -$$

+ CH₅ -

SLOT 3 / RACK 0
Allen Bradley
1756-|R6|

IW02_5
W[4778]

IW02_6
W[4781]

IW03_3
W[4790]

IW03_4
W[4793]

W03_5
W[4796]

IW03_6
W[4799]

File Name : P33-34 slot 3 Allen Bradley 1756-IR6I.dwg

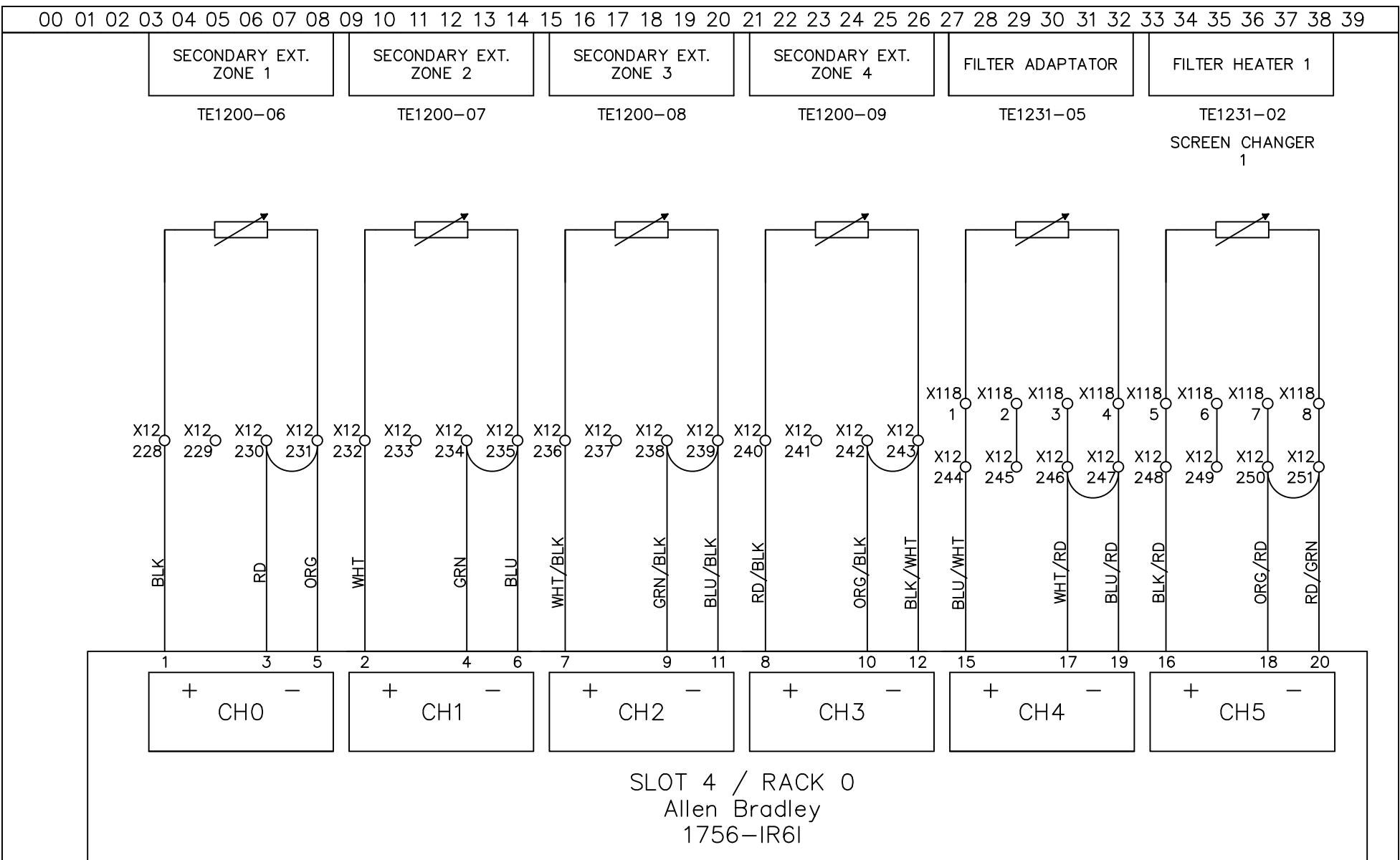
00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIVI. M/E DEPT.

Line4 6 P.L.C. ANALOG INPUT
PT100 Probe °F

				DRAWING DESCRIPTION	KFO23 F12 X12 DOOR 1	Page #	33-34		
					Total				
1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM



IW04_3
W[4807]

IW04_4
W[4810]

IW04_5
W[4813]

IW04_6
W[4816]

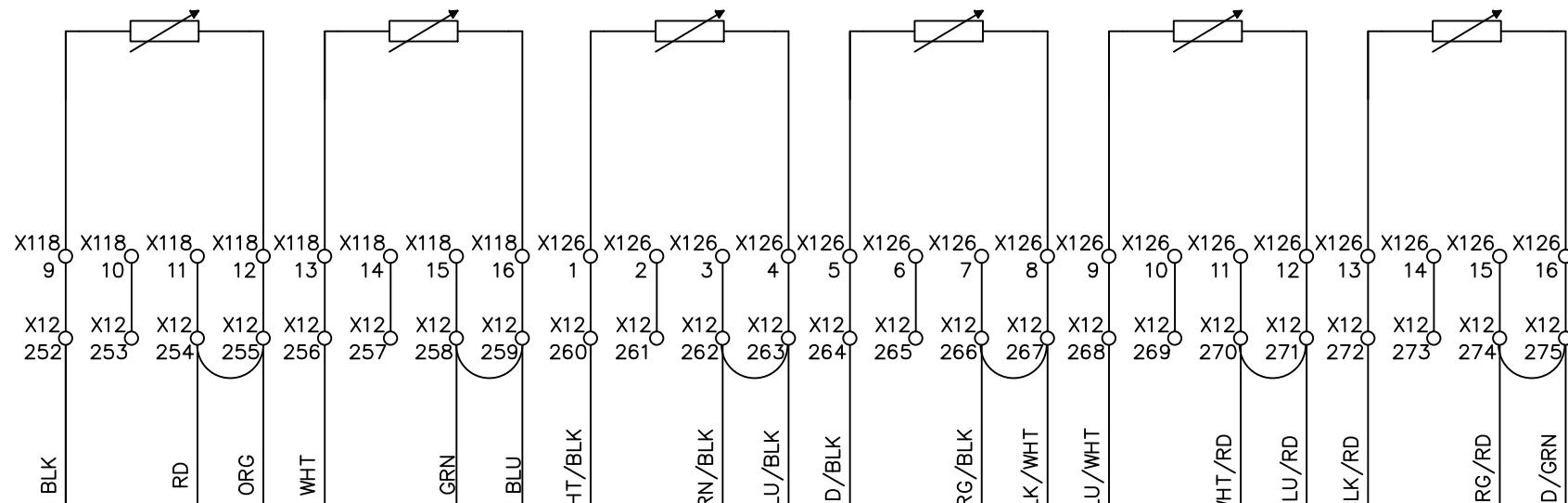
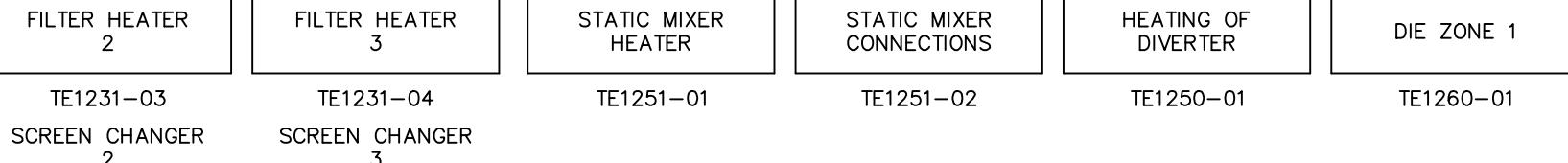
IW05_3
W[4819]

IW05_4
W[4822]

File Name : P35-36 slot 4 Allen Bradley 1756-IR6I.dwg

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 INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.	Line4 6 P.L.C. ANALOG INPUT PT100 Probe °F														DRAWING DESCRIPTION		KF023 F12 X12 DOOR 1		Page #		35-36																		
DRAWN BY	Rufus Huang																				Total																		
CHECKED BY	JERRY WU											REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM																		

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



1 3 5 2 4 6 7 9 11 8 10 12 15 17 19 16 18 20

+ CHO	- CH1	+ CH2	- CH3	+ CH4	- CH5
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SLOT 5 / RACK 0
Allen Bradley
1756-IR6I

IW05_5
W[4825]

IW05_6
W[4828]

IW06_3
W[4837]

IW06_4
W[4840]

IW06_5
W[4843]

IW06_6
W[4852]

File Name : P36-37 slot 5 Allen Bradley 1756-IR6I.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIVI. M/E DEPT.

Line4 6 P.L.C. ANALOG INPUT
PT100 Probe °F

				DRAWING DESCRIPTION	KF023 F12 X12 DOOR 1	Page #	36-37		
						Total			
1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE

FREE

FREE

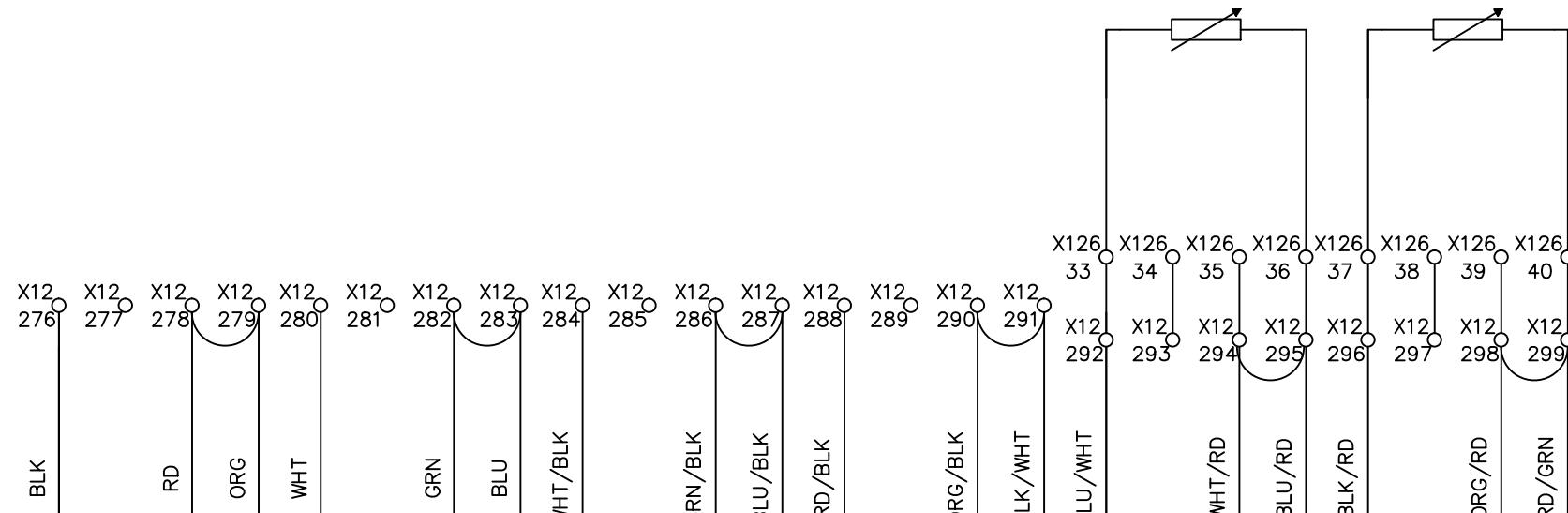
FREE

DIE ZONE 6

DIE ZONE 7

TE1260-06

TE1260-07



+ CHO -

+ CH1 -

+ CH2 -

+ CH3 -

+ CH4 -

+ CH5 -

SLOT 6 / RACK 0
Allen Bradley
1756-IR6I

IW07_3

IW07_4

IW07_5

IW07_6

IW40_3

W[4867]

IW40_4

W[4870]

File Name : P38-40 slot 6 Allen Bradley 1756-IR6I.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.Line4 6 P.L.C. ANALOG INPUT
PT100 Probe °FDRAWING
DESCRIPTION
KF023_E12
X12 DOOR 1Page #
38-40
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

SECOND. MELT
LINE-1 PART.

SECOND. MELT
LINE-2 PART.

DIE ZONE 2

DIE ZONE 3

DIE ZONE 4

DIE ZONE 5

TE1240-03

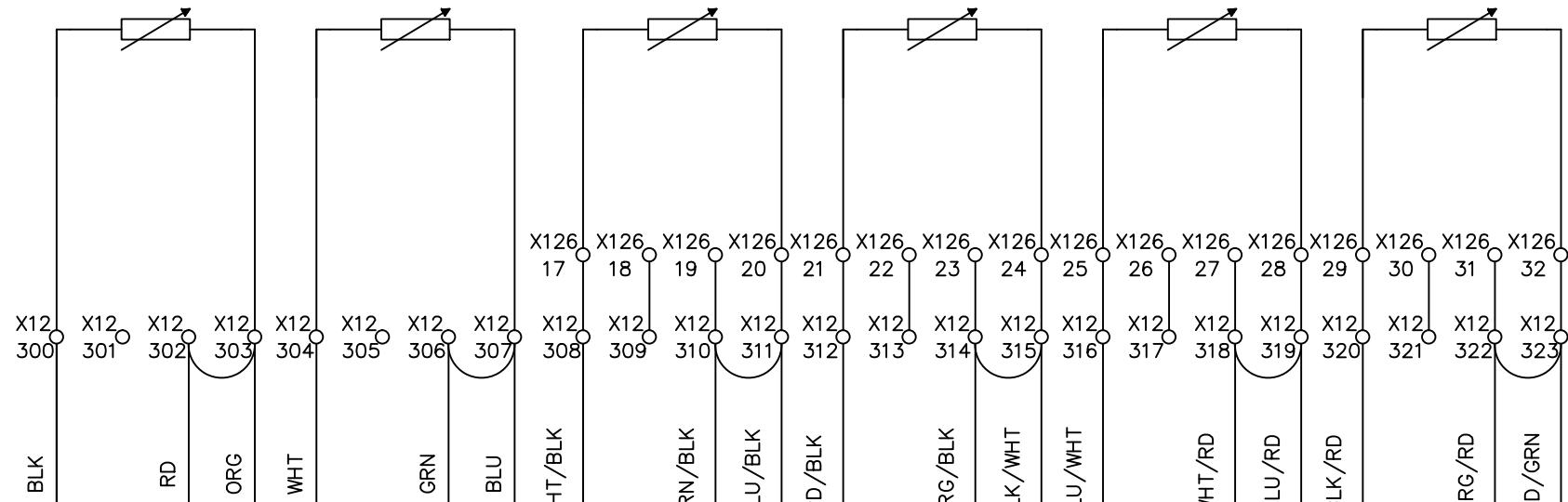
TE1240-04

TE1260-02

TE1260-03

TE1260-04

TE1260-05



1 3 5

A horizontal number line starting at 0 and ending at 6. There are tick marks at every integer from 0 to 6. The tick mark for the number 2 is enclosed in a small square box.

7 9 11

8 10 12

15 17 1

16 18 2

SLOT 7 / RACK 0
Allen Bradley
1756-IR6I

IW40_5
W[4731]

IW40_6
W[4734]

W41_3
W[4855]

IW41_4
W[4858]

IW41_5
W[4861]

|W41_6
W[4864]

File Name : P40-41 slot 7 Allen Bradley 1756-IR6I.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIVI. M/E DEPT.

Line4 6 P.L.C. ANALOG INPUT
PT100 Probe °F

				DRAWING DESCRIPTION	DRAWING DESCRIPTION	Page #	40-41		
						Total			
1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

SAT EXT. 1 ZONE 1

SAT EXT. 1 ZONE 2

SAT EXT. 1 ZONE 3

SAT EXT. 1 ZONE 4

SAT EXT. 1 ZONE 5

SAT EXT. 1 ZONE 6

TE1210-01

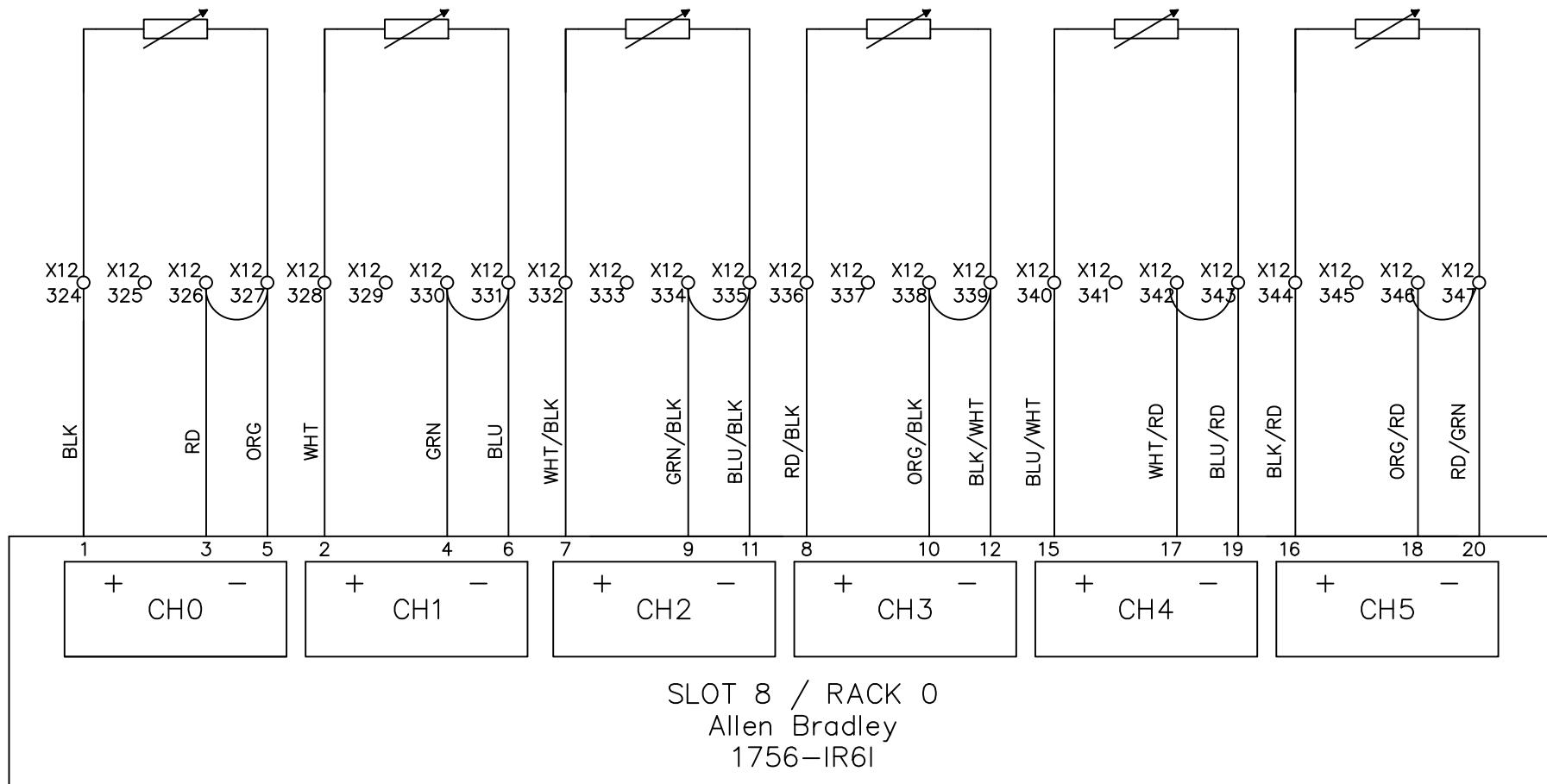
TE1210-02

TE1210-03

TE1210-04

TE1210-05

TE1210-06



IW42_3
W[4700]

IW42_4
W[4703]

IW42_5
W[4706]

IW42_6
W[4709]

IW43_3
W[4712]

IW43_4
W[4715]

File Name : P42-43 slot 8 Allen Bradley 1756-IR6I.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIVI. M/E DEPT.

Line4 6 P.L.C. ANALOG INPUT
PT100 Probe °F

				DRAWING DESCRIPTION	KF023 F12 X12 DOOR 1	Page #	42-43		
					Total				
1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

SAT EXT. 2 ZONE 1

SAT EXT. 2 ZONE 2

SAT EXT. 2 ZONE 3

SAT EXT. 2 ZONE 4

SAT EXT. 2 ZONE 5

SAT EXT. 2 ZONE 6

TE1210-15

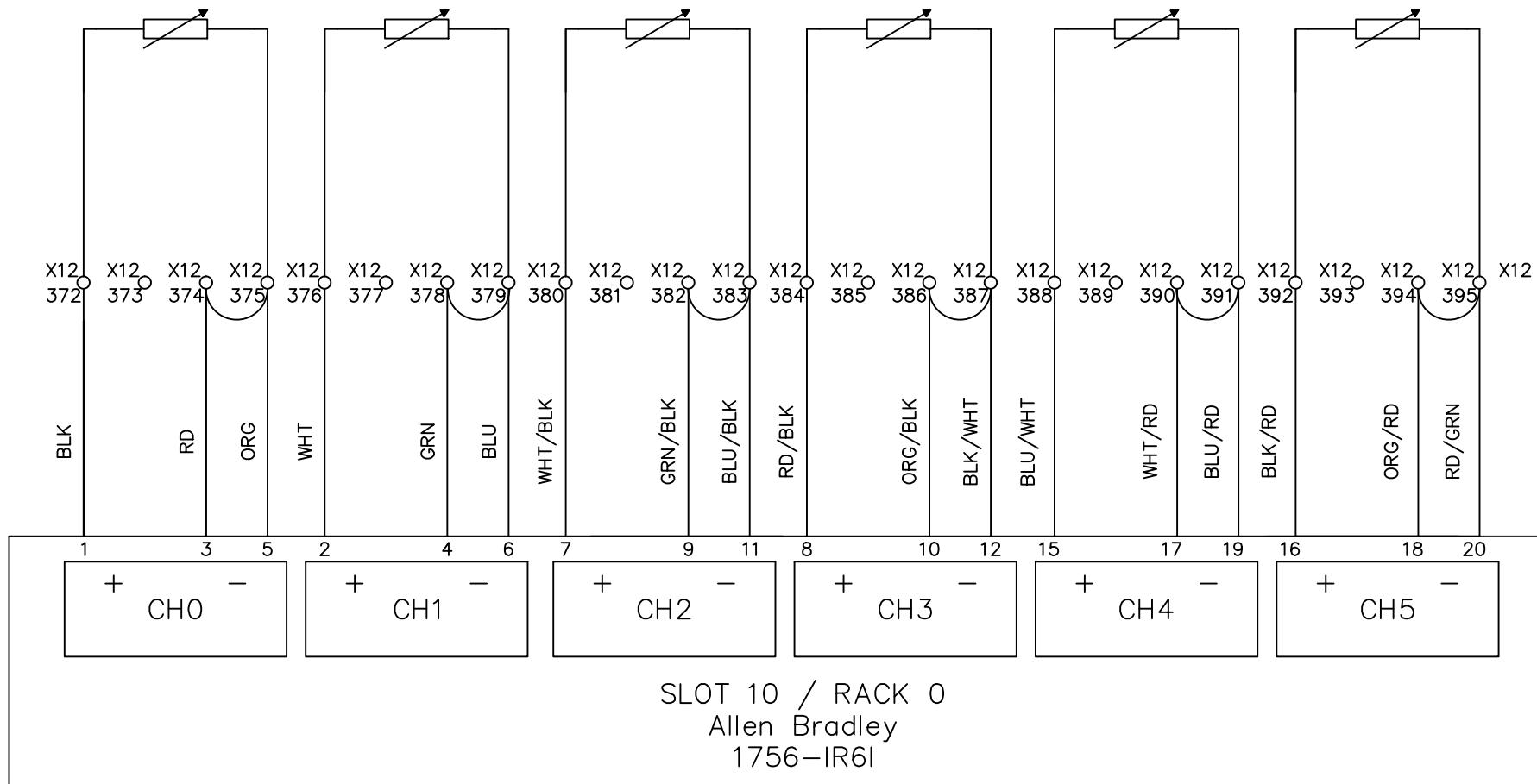
TE1210-16

TE1210-17

TE1210-18

TE1210-19

TE1210-20



IW45_3
W[4730]

IW45_4
W[4733]

IW45_5
W[4736]

IW45_6
W[4739]

IW46_3
W[4742]

IW46_4
W[4745]

File Name : P45-46 slot 10 Allen Bradley 1756-IR6I.dwg

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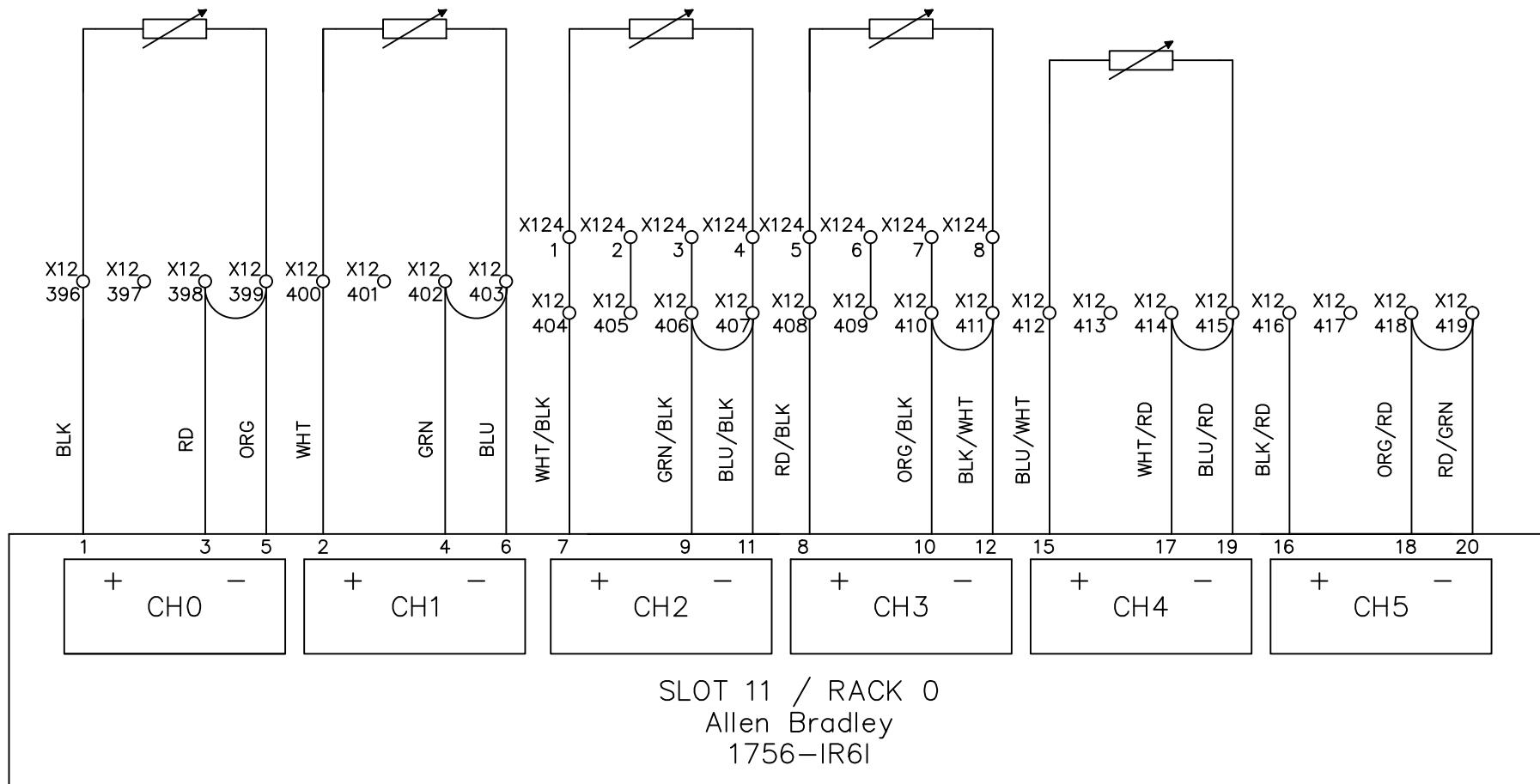
INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 6 P.L.C. ANALOG INPUT
PT100 Probe °F

				DRAWING DESCRIPTION	KF023 F12 X12 DOOR 1	Page #	45-46		
						Total			
1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

SAT EXT. 2 ZONE 7	SAT EXT. 2 ADAPT.	SAT. EXT. 2 FILTER	SAT. EXT. 2 MELT LINE	MONOLAYER ZONE3	FREE
TE1210-21	TE1210-30	TE1232-02	TE1245-02		



|W46_5
W[4778]

IW46_6
W[4781]

IW47_3
W[4790]

IW47_4
W[4793]

IW47_5
W[4796]

IW47_6
W[4799]

File Name : P46-47 slot 11Allen Bradley 1756-IR6I.dwg

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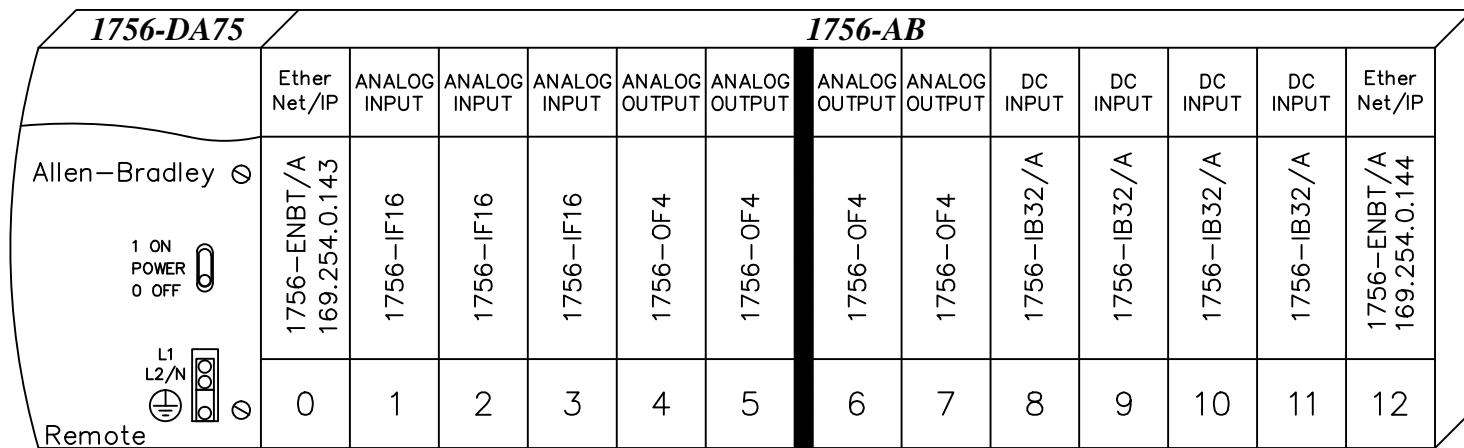
INTEPLAST GROUP, Ltd.
AMTOPP DIVI. M/E DEPT.

Line4 6 P.L.C. ANALOG INPUT
PT100 Probe °F

				DRAWING DESCRIPTION	KF023 F12 X12 DOOR 1	Page #	46-47		
					Total				
1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

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RACK 1



REMOTE I/O

File Name : P48 Rack1.dwg

01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
	INTEPLAST GROUP, Ltd.	AMTOPP DIV. M/E DEPT.																											KF023	Page #	48		
DRAWN BY	Rufus Huang																												F12	Total			
CHECKED BY	JERRY WU																												MATERIAL				

Line4 RACK 1, 1756-A13
13-SLOT CONTROL LOGIX CHASSIS

REV. NO REV. DESCRIPTION REV. BY: REV. DATE DRAWN DATE: 05-01-2018 SCALE NONE UNIT MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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MELT TEMP. AFTER
PRIMARY EXT.

TE1200-16

T510

MELT PRESS. AFTER
PRIMARY EXT.

PE1200-17

P511

MELT PRESS.
BEFROE SEC. EXT.

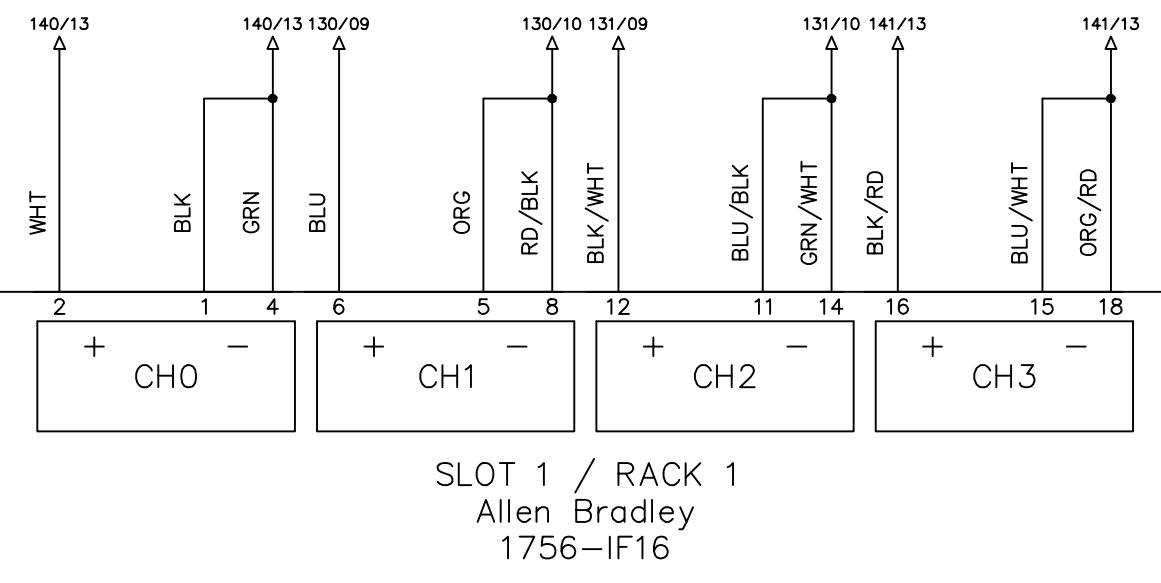
PE1200-18

P512

MELT TEMP AFTER
SEC. EXT.

TE1200-19

T513



IW62_3_0

W[4888]

IW62_4_0

W[4889]

IW62_5_0

W[4890]

IW62_6_0

W[4891]

File Name : P57 slot 1 Allen Bradley 1756-IF16-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 8 P.L.C. ANALOG INPUT
4-20mA

DRAWING
DESCRIPTION
KF023_E12
X12 DOOR 1

Page #
57
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.			MATERIAL		
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----

MELT PRESS. AFTER
SEC. EXT.

MELT TEMP.
BEFORE DIE

MELT PRESS.
BEFROE DIE

WEIGHING OF DOSEING
HOPPER

PE1200-20

TE1250-02

PE1250-03

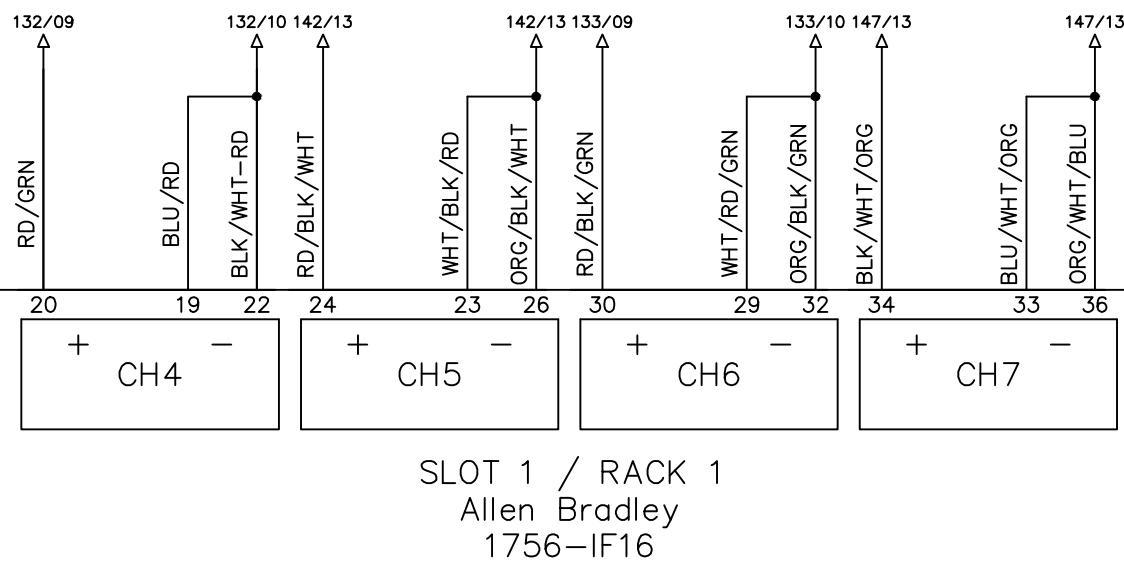
WT1115

P514

T515

P516

R200



IW62_3_1

W[4892]

IW62_4_1

W[4893]

IW62_5_1

W[4894]

IW62_6_1

W[4876]

File Name : P58 slot 1 Allen Bradley 1756-IF16-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 8 P.L.C. ANALOG INPUT
4-20mA

DRAWING
DESCRIPTION
KF023_E12
X12 DOOR 1

Page #
58

Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.			MATERIAL		
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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MELT PRESS. AFTER
SAT. EXT. 1

PE1210-31

P501

MELT TEMP. AFTER
SAT. EXT. 1

TE1210-32

T500

MELT PRESS. AFTER
SAT. EXT. 2

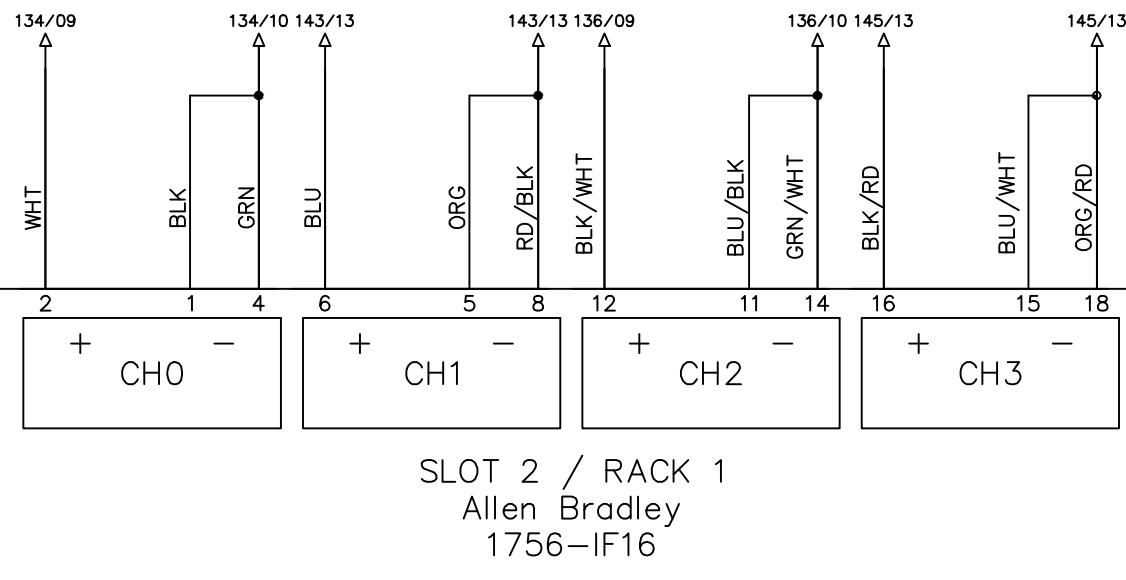
PE1210-33

P505

MELT TEMP. AFTER
SAT. EXT. 2

TE1210-34

T504



IW63_3_0

W[4881]

IW63_4_0

W[4880]

IW63_5_0

W[5885]

IW63_6_0

W[4884]

File Name : P59 slot 2 Allen Bradley 1756-IF16-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 8 P.L.C. ANALOG INPUT
4-20mA

KF023 F12
X12 DOOR 1

Page #
59

Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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MELT TEMP. BEFORE DIE	MELT PRESS. BEFORE DIE	MELT TEMP. BEFORE DIE	MELT PRESS. BEFORE DIE
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TE1235-01

T502

PE1235-03

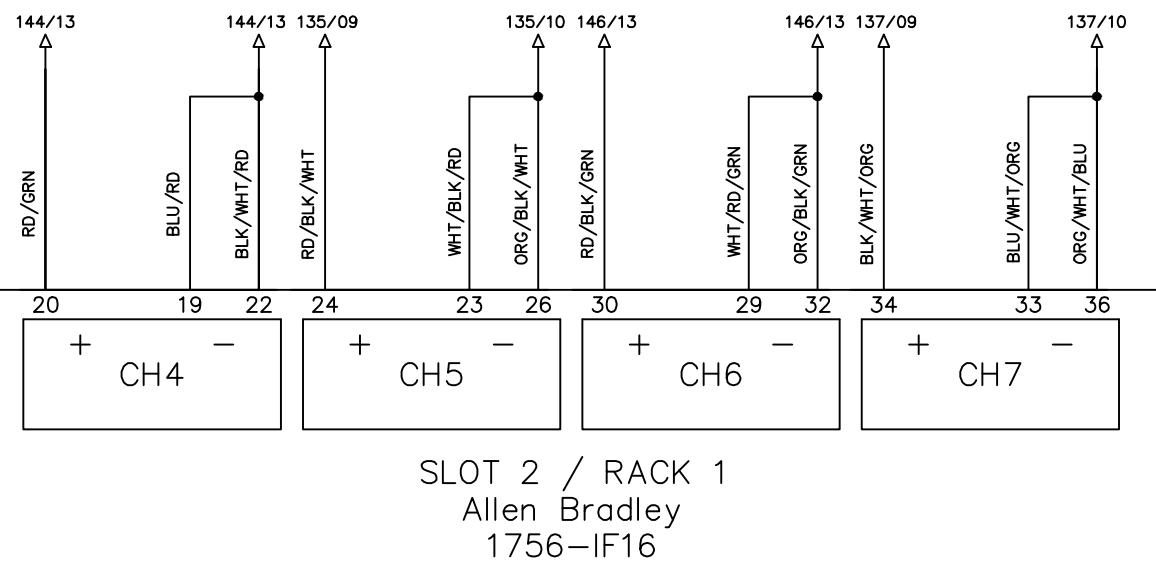
P503

TE1235-02

T506

PE1235-04

P507



IW63_3_1

W[4882]

IW63_4_1

W[4883]

IW63_5_1

W[4886]

IW63_6_1

W[4887]

File Name : P60 slot 2 Allen Bradley 1756-IF16-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.Line4 8 P.L.C. ANALOG INPUT
4-20mA

DRAWN BY	CHECKED BY	DRAWING DESCRIPTION				KF023 F12 X12 DOOR 1	Page #	60
		1	Add Terminal Number	Charlie Z.	05/23/19			
		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE NONE UNIT MM

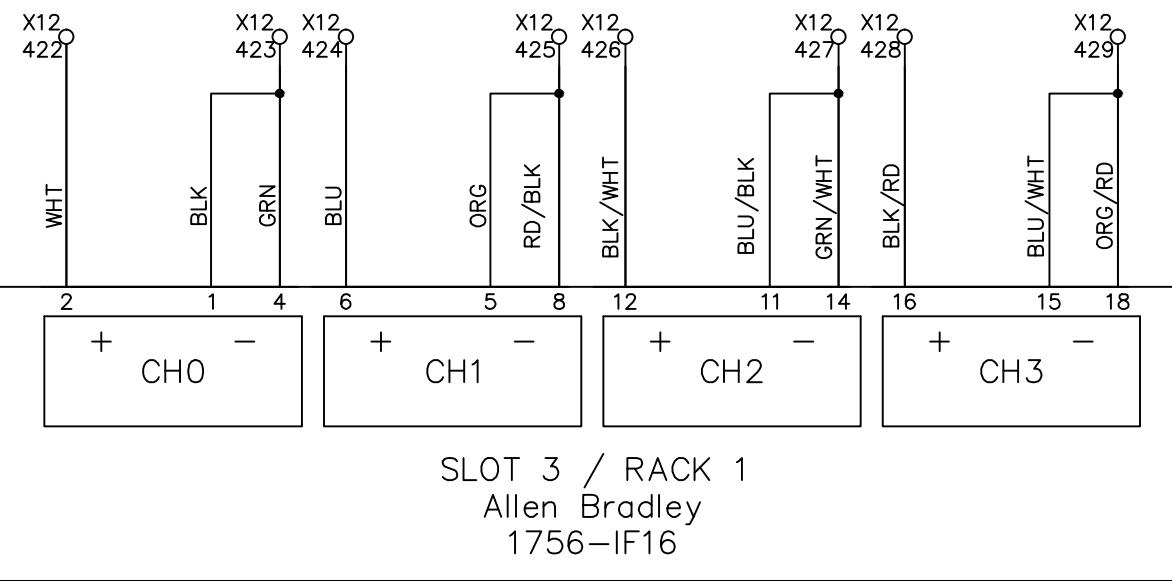
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FREE

FREE

FREE

FREE



IW64_3_0

IW64_4_0

IW64_5_0

IW64_6_0

File Name : P61 slot 3 Allen Bradley 1756-IF16-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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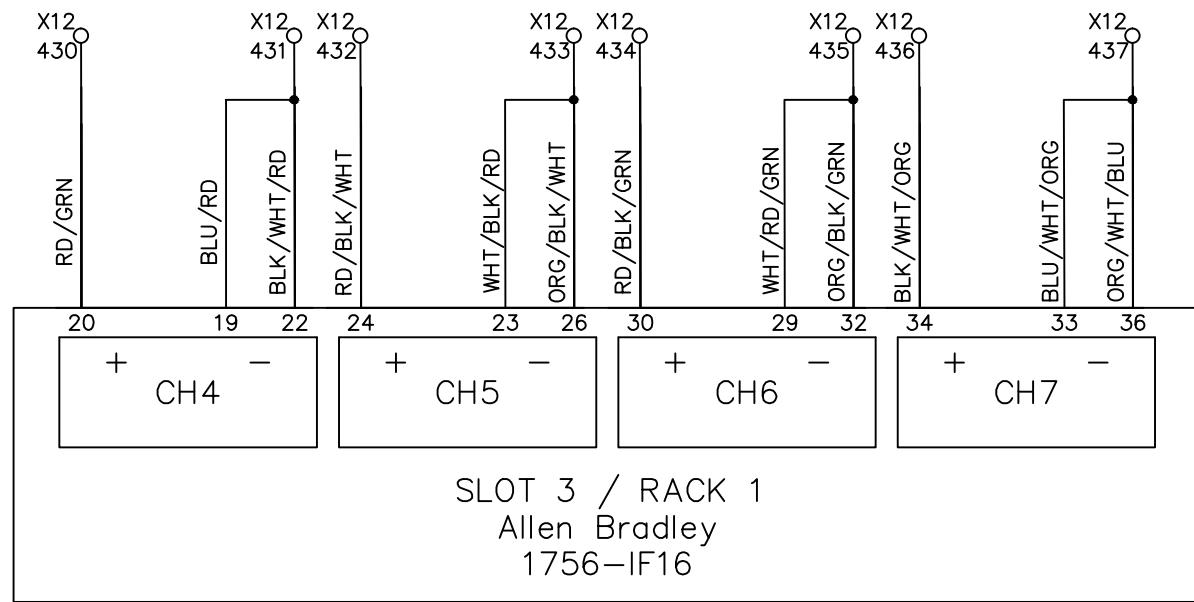
INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.Line4 8 P.L.C. ANALOG INPUT
4-20mADRAWING DESCRIPTION
KF023 F12
X12 DOOR 1Page #
61
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



IW64_3_1

IW64_4_1

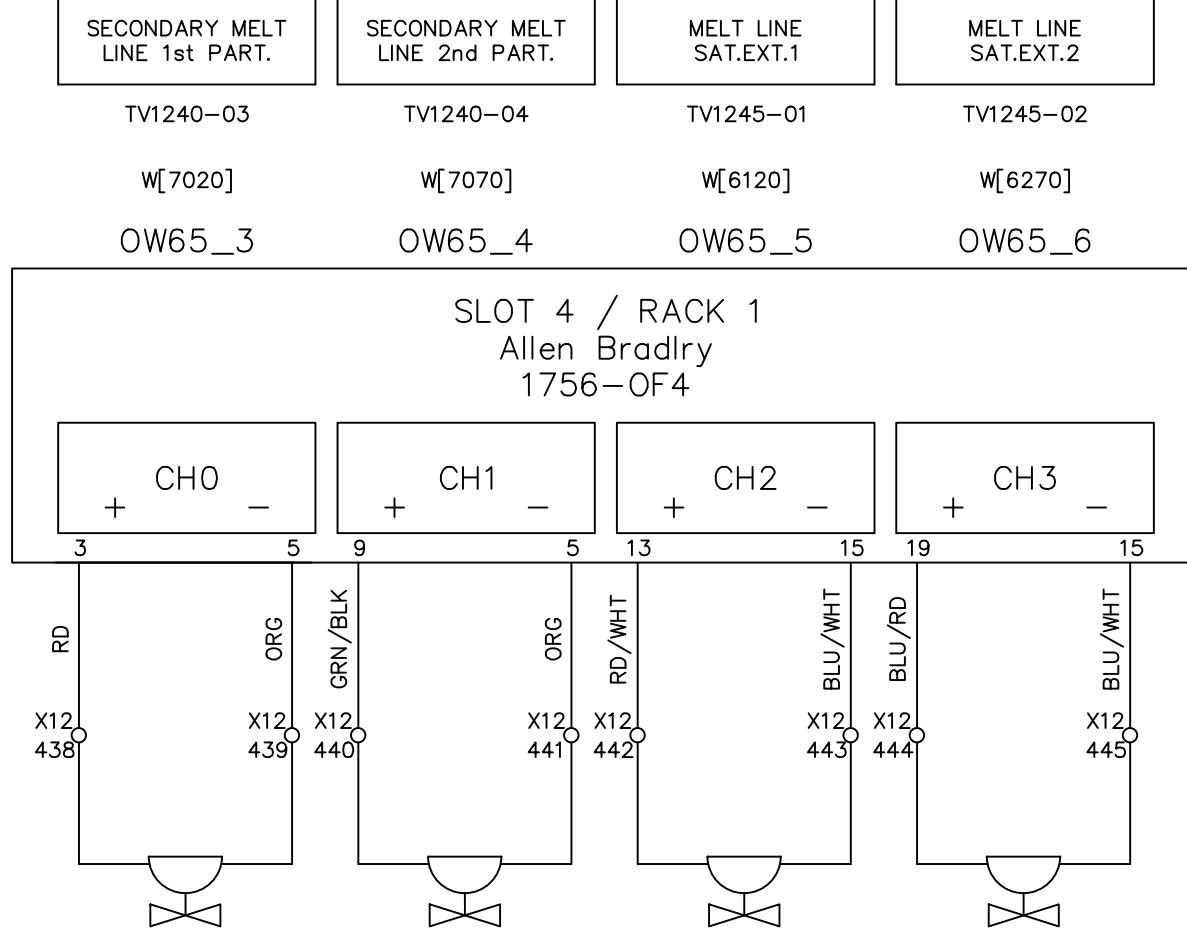
IW64_5_1

IW64_6_1

File Name : P62 slot 3 Allen Bradley 1756-IF16-2.dwg

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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.		Line4 8 P.L.C. ANALOG INPUT 4-20mA												DRAWING DESCRIPTION		KF023 F12 X12 DOOR 1		Page #		62																		
DRAWN BY	Rufus Huang															Total																							
CHECKED BY	JERRU WU													1 Add Terminal Number		Charlie Z. 05/23/19		DRAWING NO.				MATERIAL																	
														REV. NO		REV. DESCRIPTION		REV. BY:		REV. DATE		DRAWN DATE:		05-01-2018		SCALE		NONE		UNIT		MM							

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



File Name : P63 slot 4 Allen Bradley 1756-OF4 rack1.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 4 P.L.C. ANALOG OUTPUT Rack 1

				DRAWING DESCRIPTION	KF023 F12 X12 DOOR 1	Page #	63		
						Total			
1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE

FREE

FREE

FREE

M1106-01

M1106-02

M1112-01

ALSO FOREMOST
ACTUAL WEIGHT
FOR XE01ALSO FOREMOST
WEIGHT SETPOINT
FOR XE01

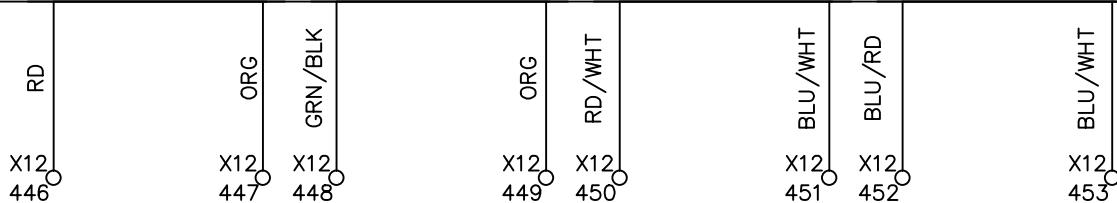
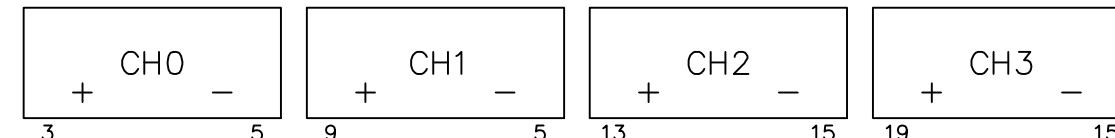
OW66_3

OW66_4

OW66_5

OW66_6

SLOT 5 / RACK 1

Allen Bradley
1756-OF4

File Name : P64 slot 5 Allen Bradley 1756-OF4 rack1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.LINE4 4 P.L.C. ANALOG OUTPUT
Rack 1

				DRAWING DESCRIPTION	KF023 F12 X12 DOOR 1	Page #		64			
						Total					
DRAWN BY	Rufus Huang			1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL	
CHECKED BY	JERRY WU	REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE

FREE

FREE

FREE

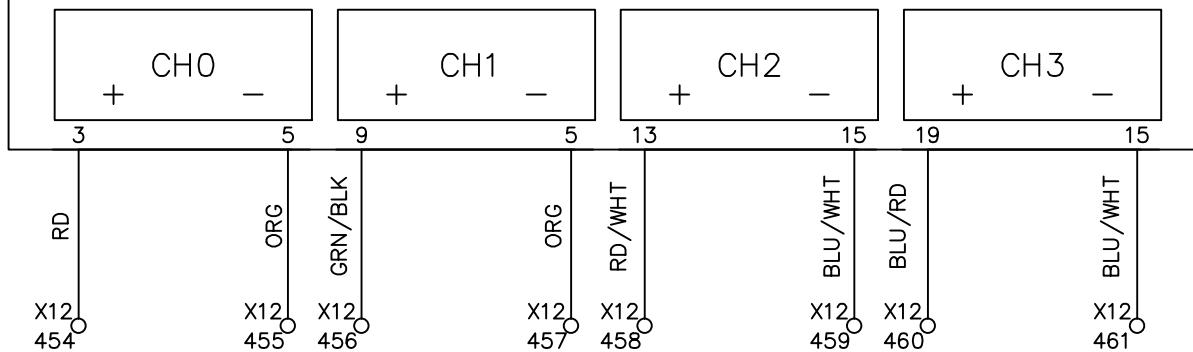
OW67_3

OW67_4

OW67_5

OW67_6

SLOT 6 / RACK 1
 Allen Bradley
 1756-OF4



File Name : P65 slot 6 Allen Bradley 1756-OF4 rack1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
 AMTOPP DIV. M/E DEPT.

Line4 4 P.L.C. ANALOG OUTPUT
 Rack 1

				DRAWING DESCRIPTION	KF023 F12 X12 DOOR 1	Page #					
						Total					
DRAWN BY	Rufus Huang			1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL	
CHECKED BY	JERRY WU	REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE

FREE

FREE

FREE

OW80_3

OW80_4

OW80_5

OW80_6

SLOT 7 / RACK 1
 Allen Bradley
 1756-OF4

+ CH0 -

3

+ CH1 -

9

+ CH2 -

13

+ CH3 -

19

15

RD

ORG

ORG

RD/WHT

BLU/WHT

BLU/RD

BLU/WHT

X12
462X12
463 X12
464X12
465 X12
466X12
467 X12
468X12
469

File Name : P67 slot 7 Allen Bradley 1756-OF4 rack1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
 AMTOPP DIV. M/E DEPT.

Line4 4 P.L.C. ANALOG OUTPUT
 Rack 1

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

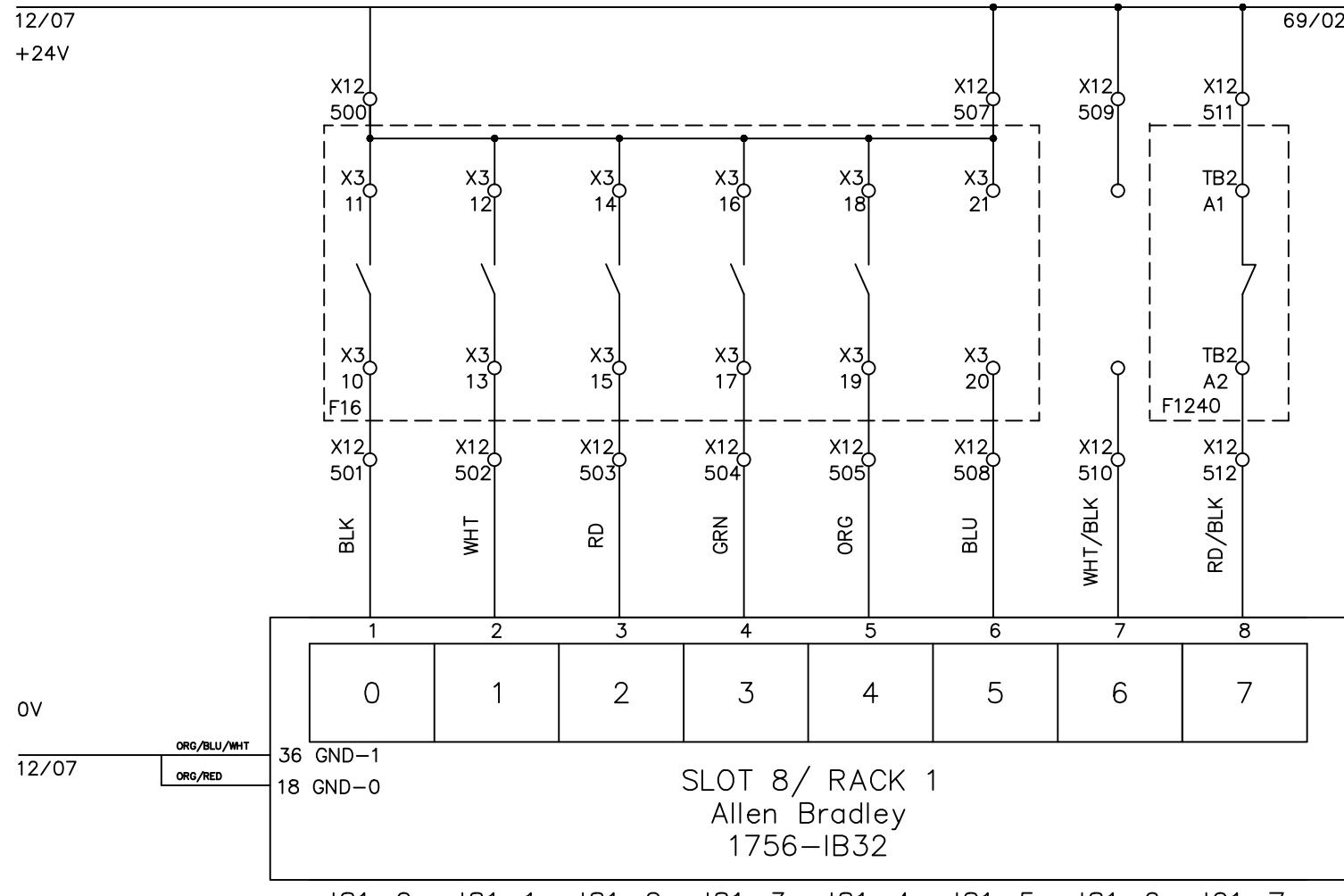
DRAWING DESCRIPTION KF023 F12
 X12 DOOR 1

Page # 67
 Total

1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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	EXT. 1 RUNNING	EXT. 2 RUNNING	SAT. 1 RUNNING	SAT. 2 RUNNING	PRODUC. STRETCH.		FREE	MELT LINE AGGREGAT OVER TEMP.
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File Name : P68 slot 8 Allen Bradley 1756-IB32 rack1-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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 INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL INPUT

			DRAWING DESCRIPTION	KF023 F12 X12 DOOR 1	Page #	68
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Total

			MATERIAL	
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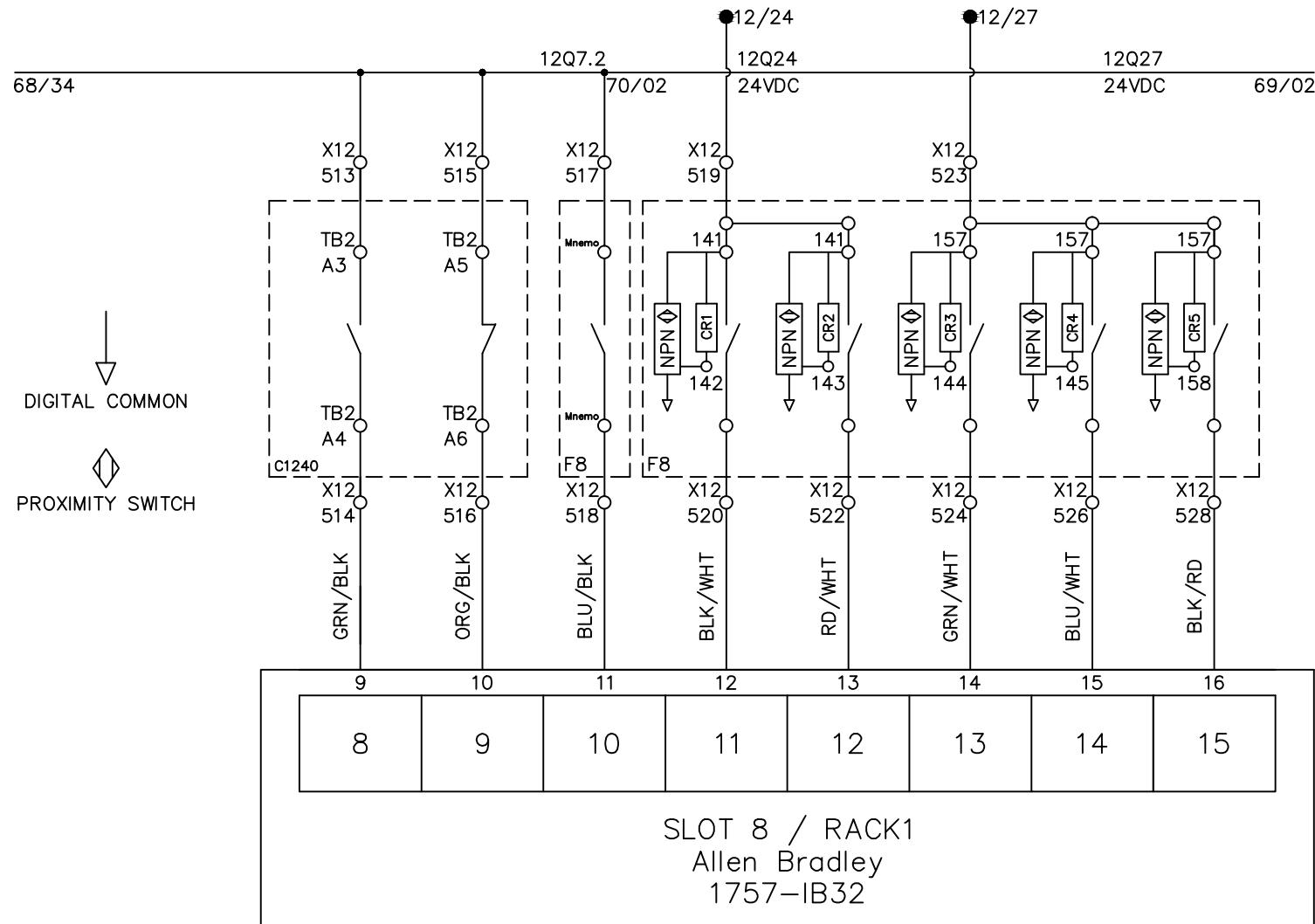
DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	06/06/19	DRAWING NO.			SCALE	NONE	UNIT	MM
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018					

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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MELT LINE AGGREGAT DEFECT HIGH LEVEL	MELT LINE AGGREGAT DEFECT LOW LEVEL	FEEDING PUMP START ORDER	RECEIVER #1 LOADER FULL	RECEIVER #2 LOADER FULL	RECEIVER #3 LOADER FULL	RECEIVER #4 LOADER FULL	RECEIVER #5 LOADER FULL
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I81_8 I81_9 I81_A I81_B I81_C I81_D I81_E I81_F
W[4941].D

File Name : P69 slot 8 Allen Bradley 1756-IB32 rack1-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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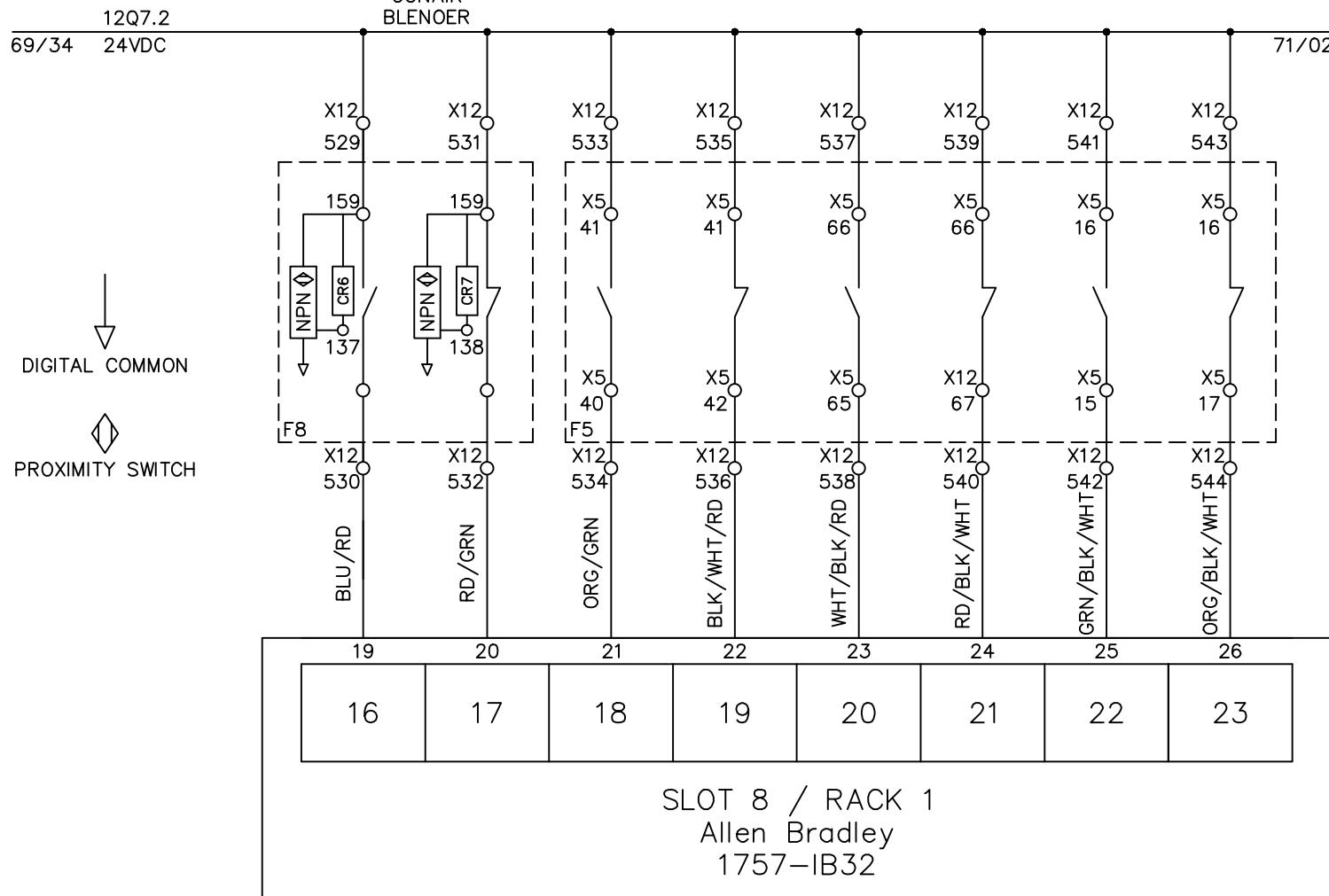
DRAWN BY	Rufus Huang	Line4 32 P.L.C. DIGITAL INPUT			DRAWMING DESCRIPTION	KF023 F12 X12 DOOR 1	Page #	69
							Total	
CHECKED BY	JERRY WU	1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL
		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE NONE UNIT MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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	MIXER FULL	MIXER EMPTY	MOTOR RUNNING	MOTOR DEFECT	MOTOR RUNNING	MOTOR DEFECT	MOTOR RUNNING	MOTOR DEFECT
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M1106-01	M1106-01	M1106-02	M1106-02	M1112-01	M1112-01
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CONAIR
BLENKER



191_0 191_1 191_2 191_3 191_4 191_5 191_6 191_7

W[7621].7

File Name : P70 slot 8 Allen Bradley 1756-IB32 rack1-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL INPUT

DRAWING DESCRIPTION KF023 E12
X12 DOOR 1,5

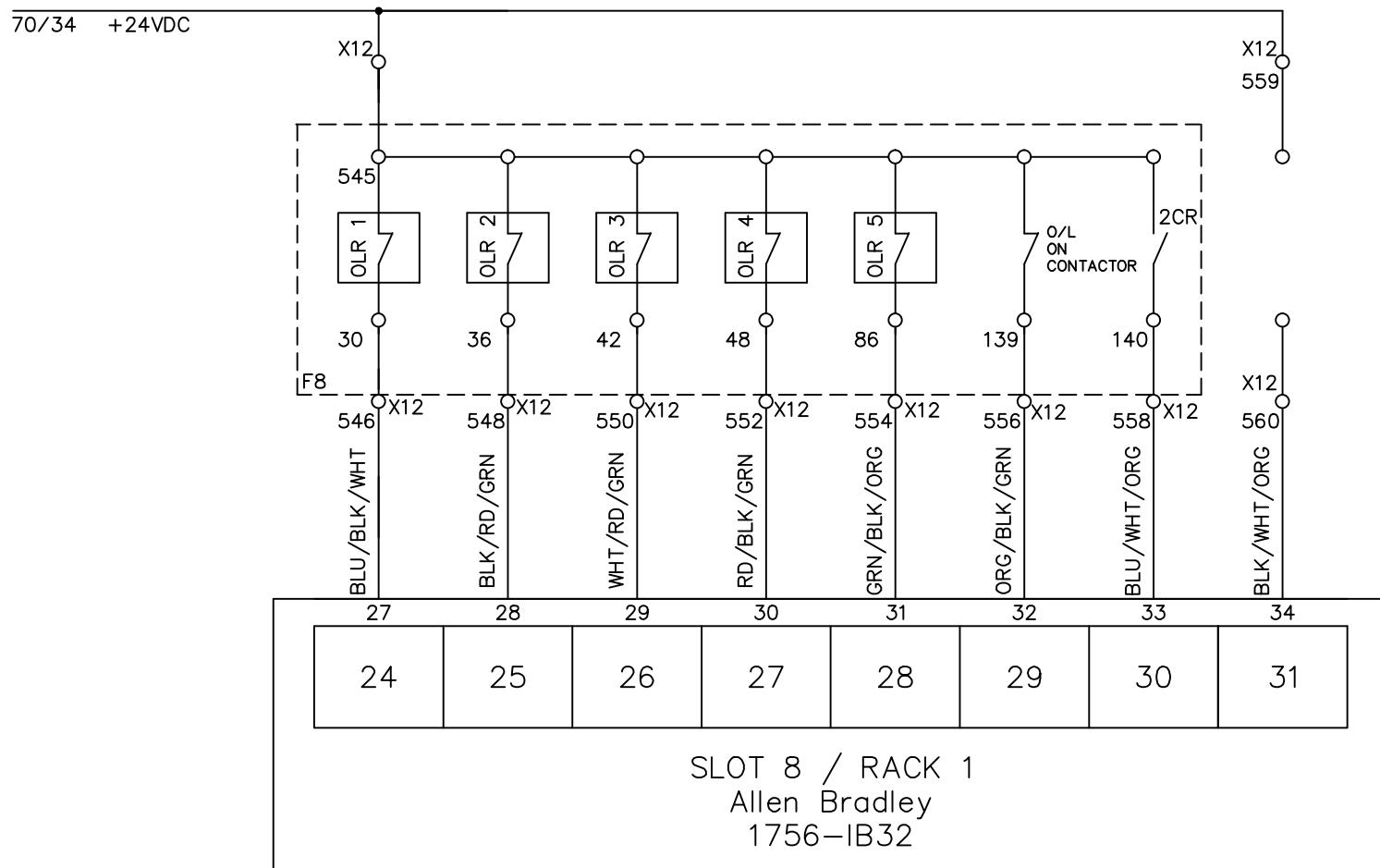
Page # 70
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL
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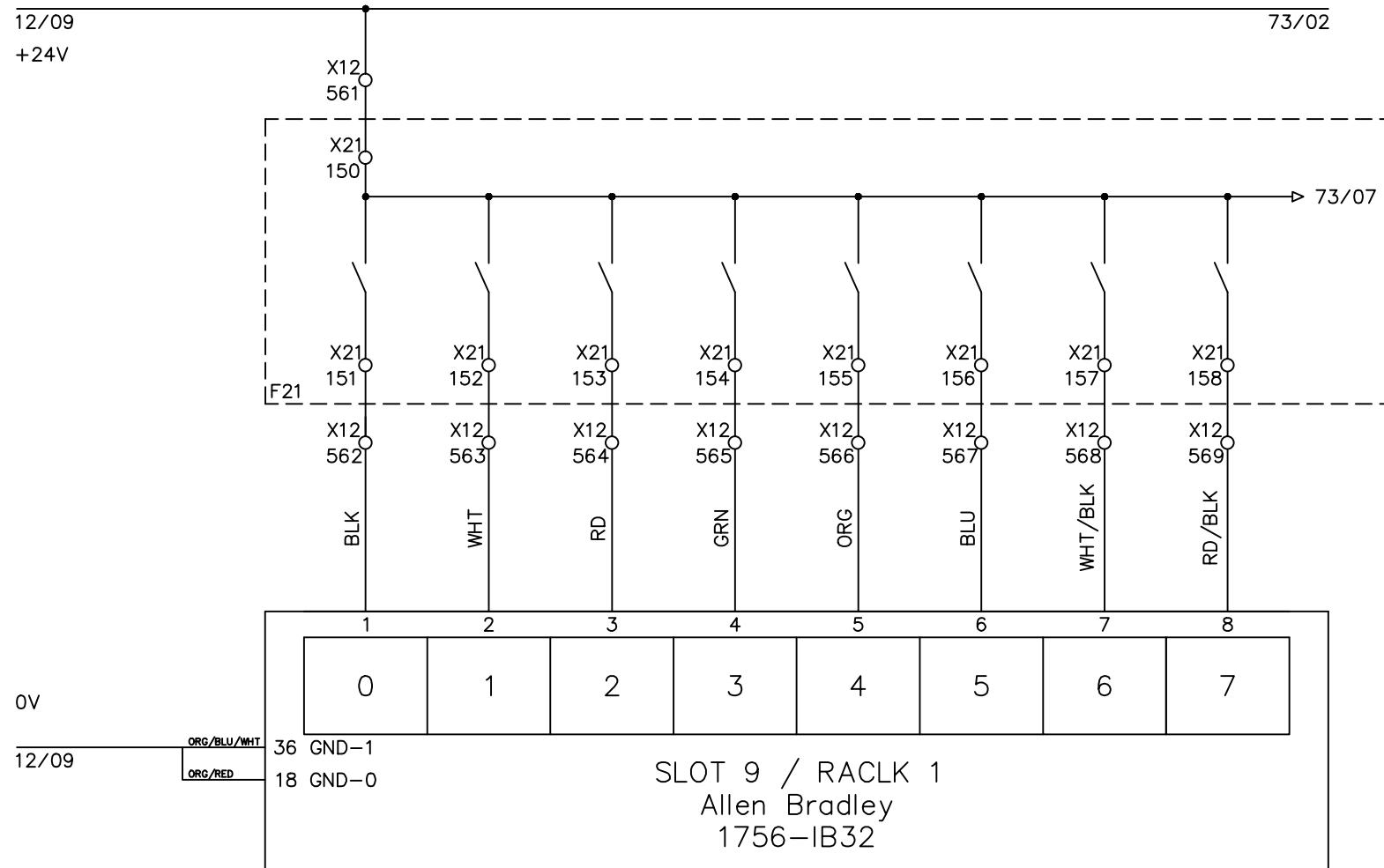
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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File Name : P71 slot 8 Allen Bradley 1756-IB32 rack1-4.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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	HEATER ZONE 1 EXT.1	HEATER ZONE 2 EXT.1	HEATER ZONE 3 EXT.1	HEATER ZONE 4 EXT.1	COOLING PUMP EXT.1	MIXING SCREW	ROTARY ARM	HEATER ZONE 1 EXT.2
	M1200-01	M1200-02	M1200-03	M1200-04	M1200-05	M1114-01	M1114-02	M1200-06



File Name : P72 slot 9 Allen Bradley 1756-IB32 rack1-1.dwg

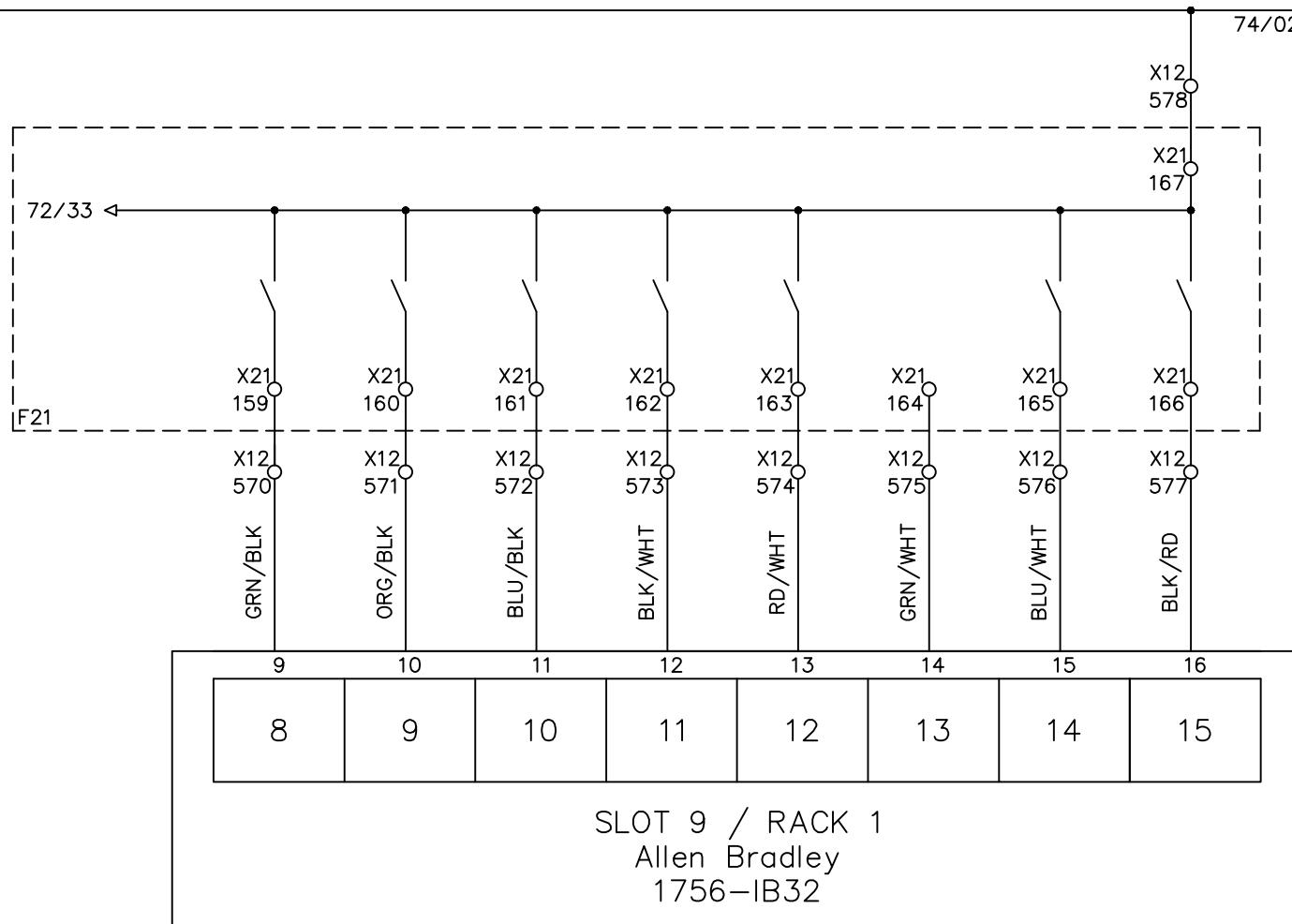
00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.																				DRAWING DESCRIPTION		KF023 E12 X12 DOOR 5	Page #		72													
DRAWN BY	Rufus Huang																				Total																		
CHECKED BY	JERRY WU																				MATERIAL																		
	Line4 32 P.L.C. DIGITAL INPUT										1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.						REV. NO.	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM									

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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	HEATER ZONE 2 EXT.2	HEATER ZONE 3 EXT.2	HEATER ZONE 4 EXT.2	COOLING PUMP EXT.2	VACUUM PUMP	FREE	MELT LINE 1 ZONE 1	MELT LINE 1 ZONE 2
	M1200-07	M1200-08	M1200-09	M1200-11	M1107-01		M1200-12	M1200-13

72/34

74/02



I82_8	I82_9	I82_A	I82_B	I82_C	I82_D	I82_E	I82_F
W[502].8	W[502].A	W[502].B	W[503].0	W[515].B		W[501].E	W[501].F

File Name : P73 slot 9 Allen Bradley 1756-IB32 rack1-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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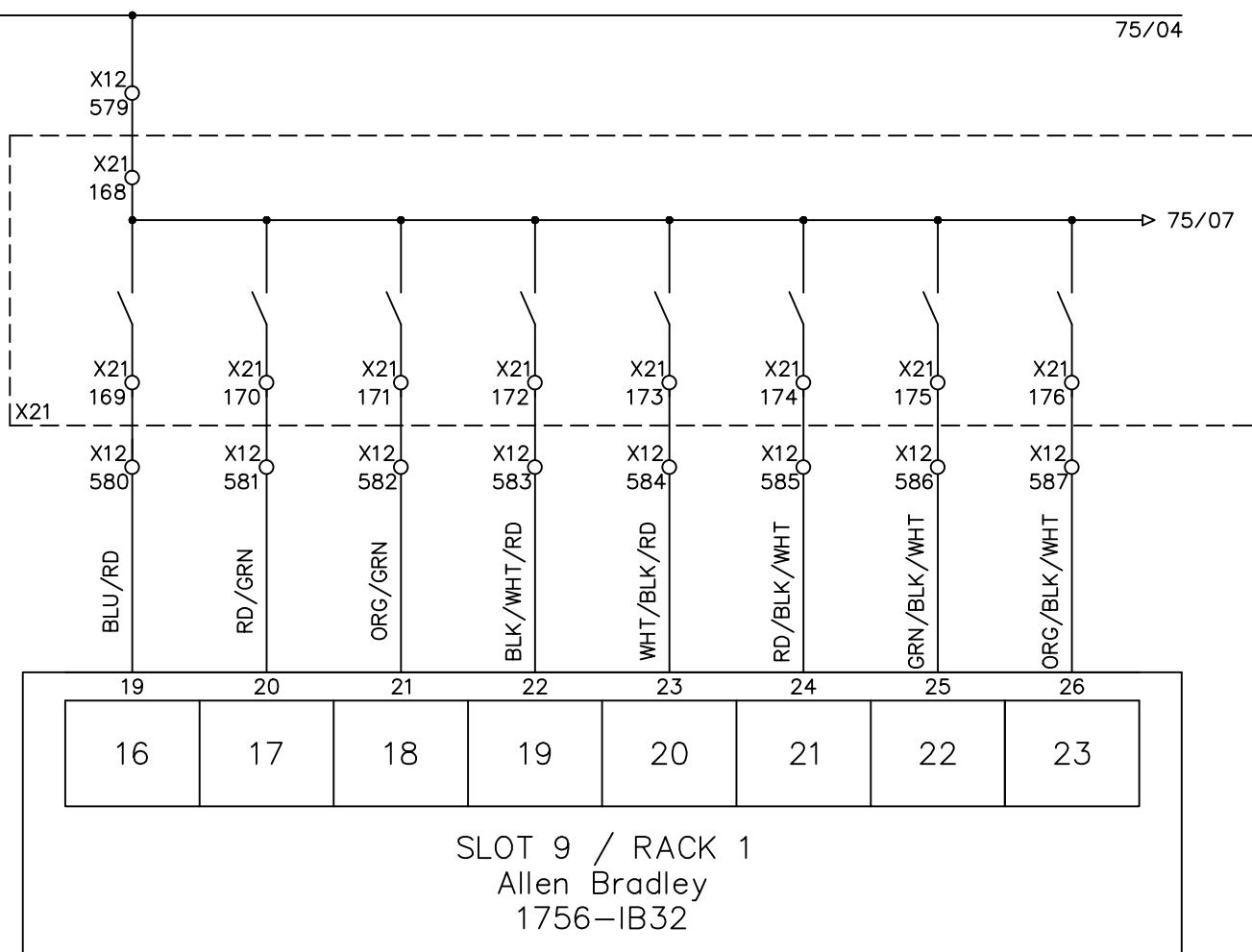
DRAWN BY	Rufus Huang	Line4 32 P.L.C. DIGITAL INPUT			REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWING NO.	DRAWING DESCRIPTION	KF023 F12	Page #	73	
											Total			
CHECKED BY	JERRY WU										MATERIAL			

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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MELT LINE 1 ZONE 3	MELT LINE 1 ZONE 4	FREE	FREE	MOTOR CHANCE FILTER EXT.1	FILTER ZONE 1	FILTER ZONE 2	FILTER ZONE 3
H1200-14	H1200-15			M1230-01	M1230-02	M1230-03	M1230-04

73/34

75/04



I92_0	I92_1	I92_2	I92_3	I92_4	I92_5	I92_6	I92_7
W[502].0	W[502].1			W[507].2	W[501].9	W[501].A	W[501].B

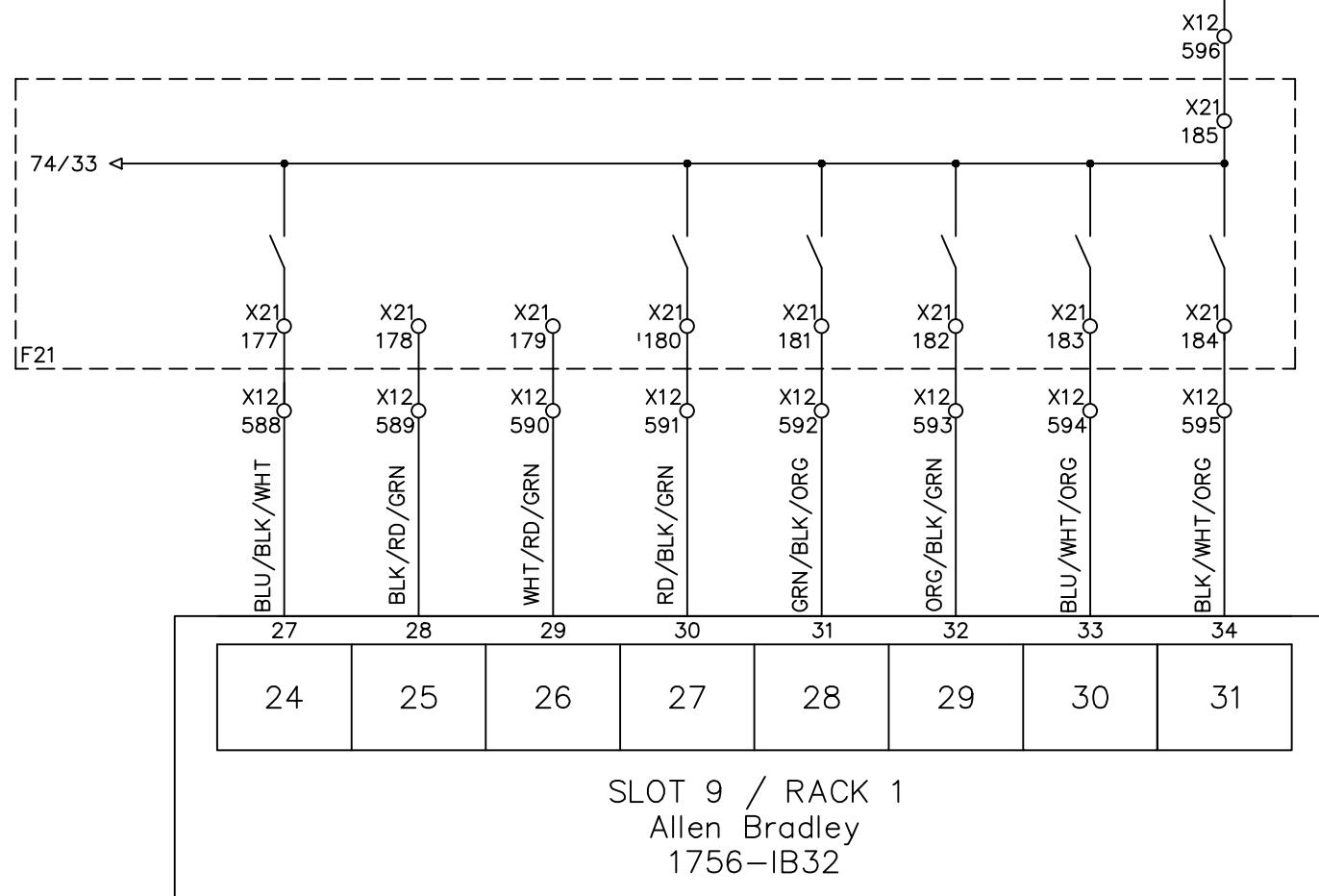
File Name : P74 slot 9 Allen Bradley 1756-IB32 rack1-3.dwg

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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.	Line4 32 P.L.C. DIGITAL INPUT				DRAWING DESCRIPTION	KF023 F12 X12 DOOR 5	Page #	74		
								Total			
DRAWN BY	Rufus Huang										
CHECKED BY	JERRY WU	1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.			MATERIAL		
		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

	ADAPTER	FREE	FREE	MOTOR CHANGE FILTER EXT.2	FILTER ZONE 1	FILTER ZONE 2	FILTER ZONE 3	ADAPTER	
	H1230-05			M1231-02	H1231-02	H1231-03	H1231-04	H1231-05	

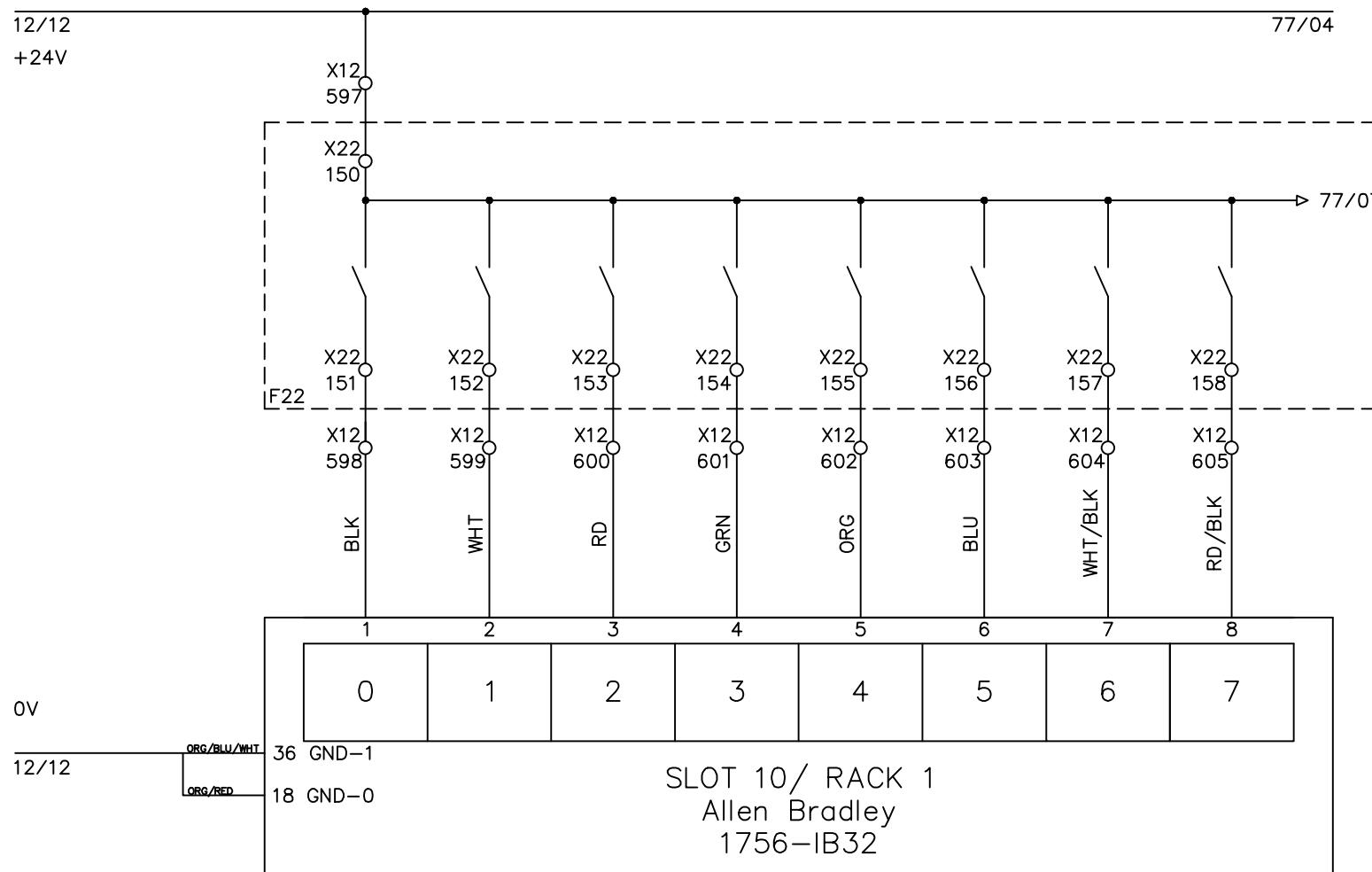
74/34



|92_8 |92_9 |92_A |92_B |92_C |92_D |92_E |92_F
W[501].8 W[507].3 W[502].D W[502].E W[502].F W[502].C

File Name : P75 slot 9 Allen Bradley 1756-IB32 rack1-4.dwg

	SAT.EXT.1 HEATER ZONE 1	SAT.EXT.1 HEATER ZONE 2	SAT.EXT.1 HEATER ZONE 3	SAT.EXT.1 HEATER ZONE 4	SAT.EXT.1 HEATER ZONE 5	SAT.EXT.1 HEATER ZONE 6	SAT.EXT.1 HEATER ZONE 7	ADAPT.SAT. EXT.1
	H1210-01	H1210-02	H1210-03	H1210-04	H1210-05	H1210-06	H1210-07	H1210-29



|83_0 |83_1 |83_2 |83_3 |83_4 |83_5 |83_6 |83_7
W[500].0 W[500].1 W[500].2 W[500].3 W[500].4 W[500].5 W[500].6 W[500].7

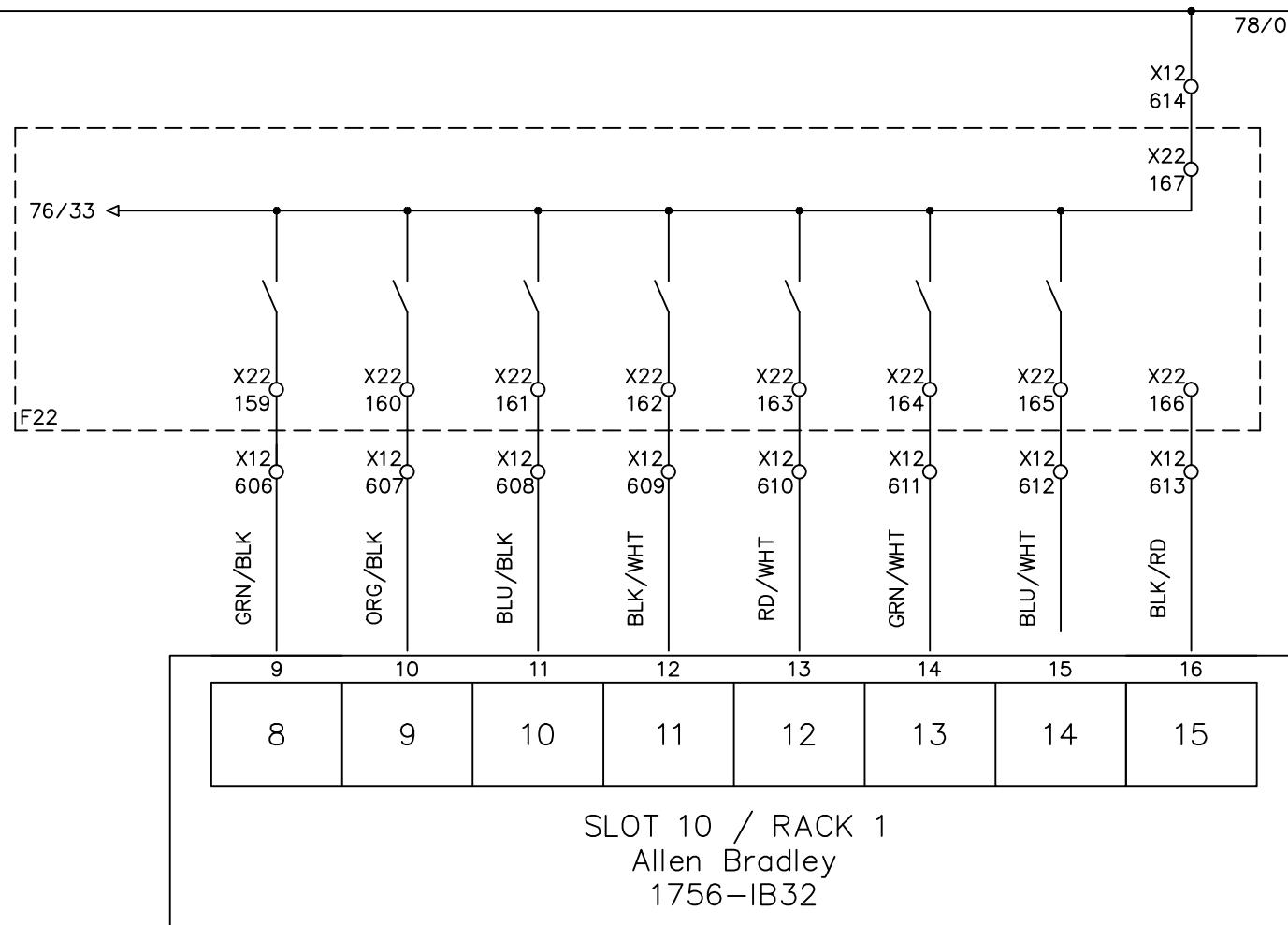
File Name : P76 slot 10 Allen Bradley 1756-IB32 rack1-1.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

COOLING FAN ZONE 1	COOLING FAN ZONE 2	COOLING FAN ZONE 3	COOLING FAN ZONE 4	COOLING FAN ZONE 5	COOLING FAN ZONE 6	COOLING FAN ZONE 7	FREE
M1210-08	M1210-09	M1210-10	M1210-11	M1210-12	M1210-13	M1210-14	

76/34

78/02



I83_8 I83_9 I83_A I83_B I83_C I83_D I83_E I83_F
W[508].0 W[508].1 W[508].2 W[508].3 W[508].4 W[508].5 W[508].6

File Name : P77 slot 10 Allen Bradley 1756-IB32 rack1-2.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

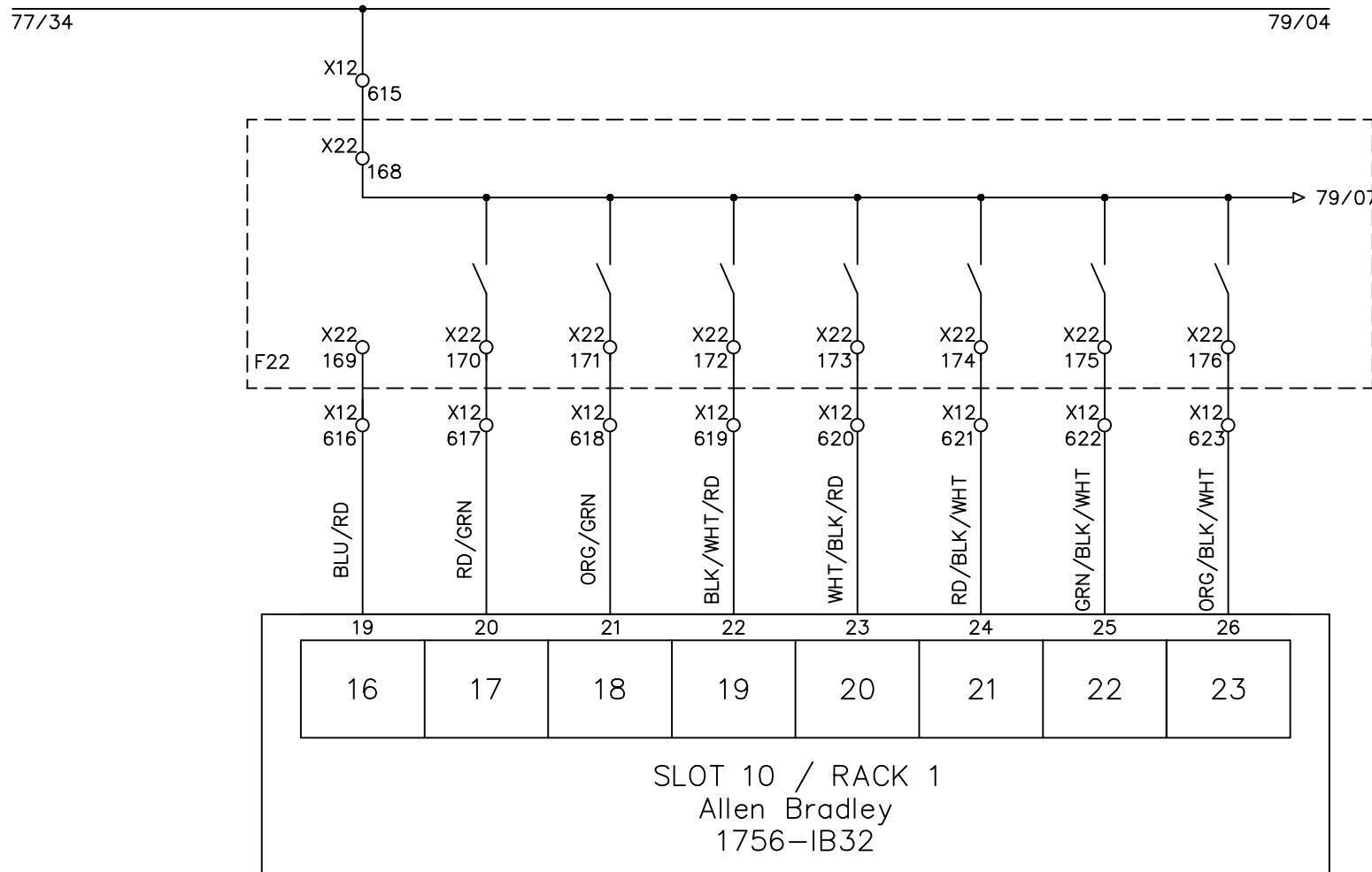
Line4 32 P.L.C. DIGITAL INPUT

DRAWN BY Rufus Huang
CHECKED BY JERRY WU

REV. NO.	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	Page #	
					KFO23 F12 X12 DOOR 5	Total
1	Add Terminal Number	Charlie Z.	05/23/19	05-01-2018		MATERIAL
						MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE	SAT.EXT.2 HEATER ZONE 1	SAT.EXT.2 HEATER ZONE 2	SAT.EXT.2 HEATER ZONE 3	SAT.EXT.2 HEATER ZONE 4	SAT.EXT.2 HEATER ZONE 5	SAT.EXT.2 HEATER ZONE 6	SAT.EXT.2 HEATER ZONE 7
	H1210-15	H1210-16	H1210-17	H1210-18	H1210-19	H1210-20	H1210-21



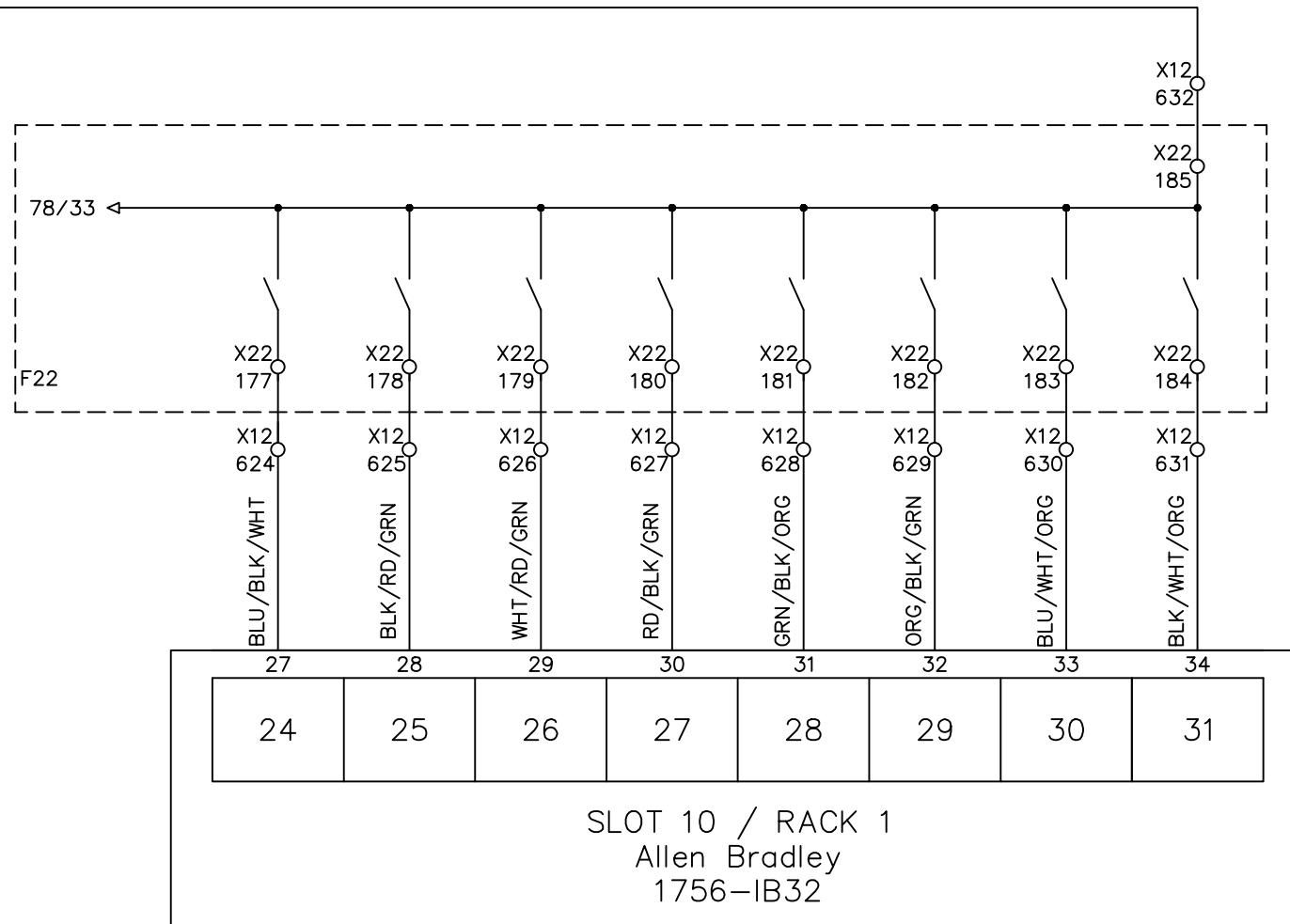
193_0	193_1	193_2	193_3	193_4	193_5	193_6	193_7
W[500].A	W[500].B	W[500].C	W[500].D	W[500].E	W[500].F	W[501].0	

File Name : P78 slot 10 Allen Bradley 1756-IB32 rack1-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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DRAWN BY	Rufus Huang	Line4 32 P.L.C. DIGITAL INPUT			DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #	78
							Total	
CHECKED BY	JERRY WU	1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		
		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE NONE UNIT MM

78/34

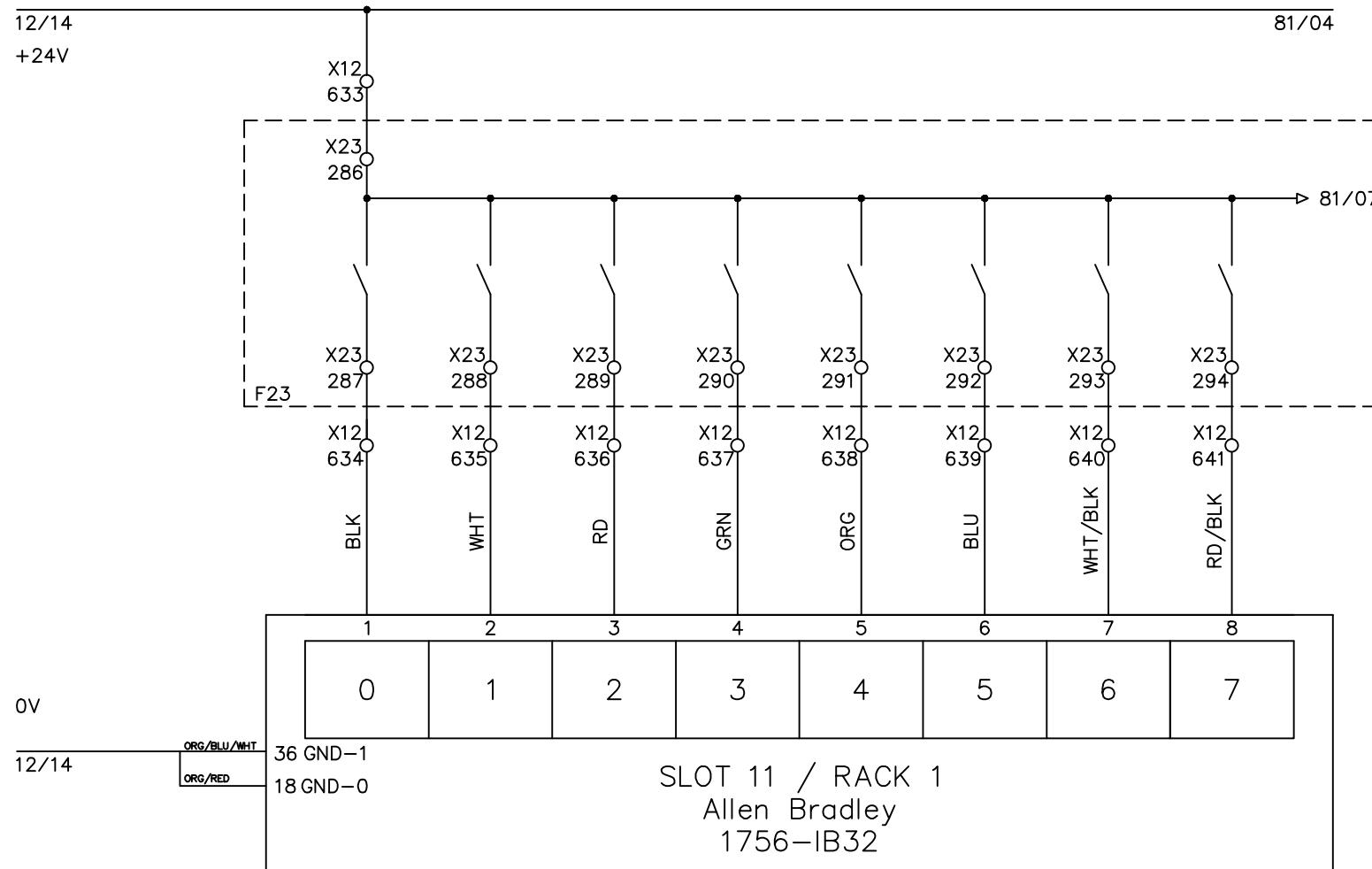


193_8 193_9 193_A 193_B 193_C 193_D 193_E 193_F
W[501].1 W[508].7 W[508].8 W[508].9 W[508].A W[508].B W[508].C W[508].D

File Name : P79 slot 10 Allen Bradley 1756-IB32 rack1-4.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
 INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.	Line4 32 P.L.C. DIGITAL INPUT															DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #	79																				
DRAWN BY	Rufus Huang																Total																						
CHECKED BY	JERRY WU															DRAWING NO.		MATERIAL																					
																REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM														

	HEATING OF DIVERTER	DIE HEATER ZONE 1	DIE HEATER ZONE 2	DIE HEATER ZONE 3	DIE HEATER ZONE 4	DIE HEATER ZONE 5	DIE HEATER ZONE 6	DIE HEATER ZONE 7
	H1250-01	H1260-01	H1260-02	H1260-03	H1260-04	H1260-05	H1260-06	H1260-07



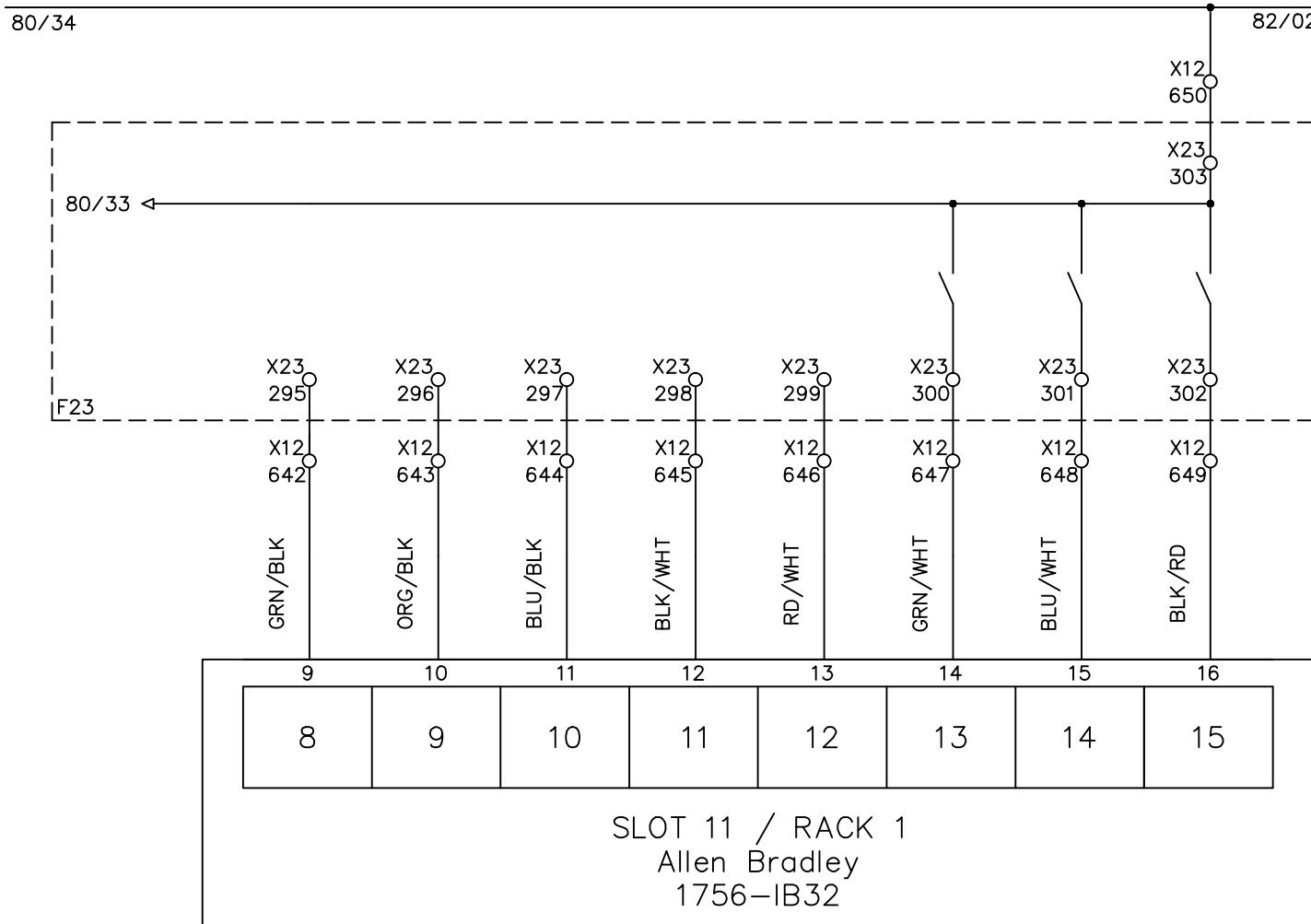
|84_0 |84_1 |84_2 |84_3 |84_4 |84_5 |84_6 |84_7
W[503].3 W[503].5 W[503].6 W[503].7 W[503].8 W[503].9 W[503].A W[503].B

File Name : P80 slot 11 Allen Bradley 1756-IB32 rack1-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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MONOLAYER ZONE1	MONOLAYER ZONE2	MONOLAYER ZONE3	FREE	FREE	STATIC MIXER HEATING	STATIC MIXR CONNECTIONS	SAT.1 HEATING FILTER
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M1251-01 M1251-02 M1232-01



184_8 184_9 184_A 184_B 184_C 184_D 184_E 184_F
W[503].2 W[503].1 W[500].8

File Name : P81 slot 11 Allen Bradley 1756-IB32 rack1-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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Line4 AB 32 P.L.C. DIGITAL INPUT

			DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #	81
					Total	

					MATERIAL	
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					SCALE	NONE	UNIT	MM
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DRAWN BY Rufus Huang

CHECKED BY JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018			
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SAT.2 HEATING FILTER	HYDRAULIC GROUP	HYDRAULIC GROUP	FREE	HOMOPOLYMER SILO LOW LEVEL	HOMOPOLYMER SILO HIGH LEVEL	RECLAIM MATERIAL LOW LEVEL	RECLAIM MATERIAL HIGH LEVEL
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DRYER

DRYER

M1232-02

M1232-03

M1232-04

LSL1104-01

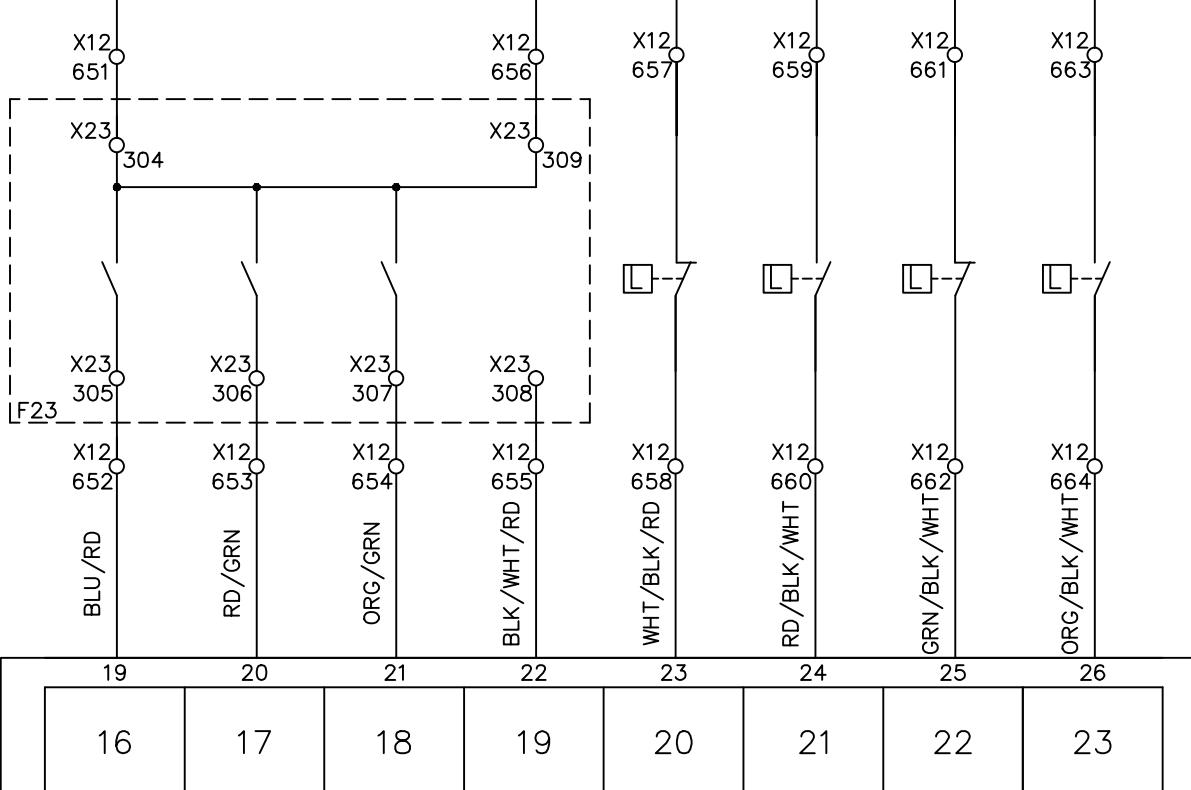
LSL1104-02

LSL1104-03

LSL1104-04

81/34

83/04



SLOT 11 / RACK 1
Allen Bradley
1756-IB32

I94_0	I94_1	I94_2	I94_3	I94_4	I94_5	I94_6	I94_7
W[501].2	W[507].0	W[507].1	W[507].2	W[507].3	W[507].4	W[507].5	W[507].6

File Name : P82 slot 11 Allen Bradley 1756-IB32 rack1-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL INPUT

DRAWING
DESCRIPTION
KF023_E12
X12 DOOR 6Page #
82
Total

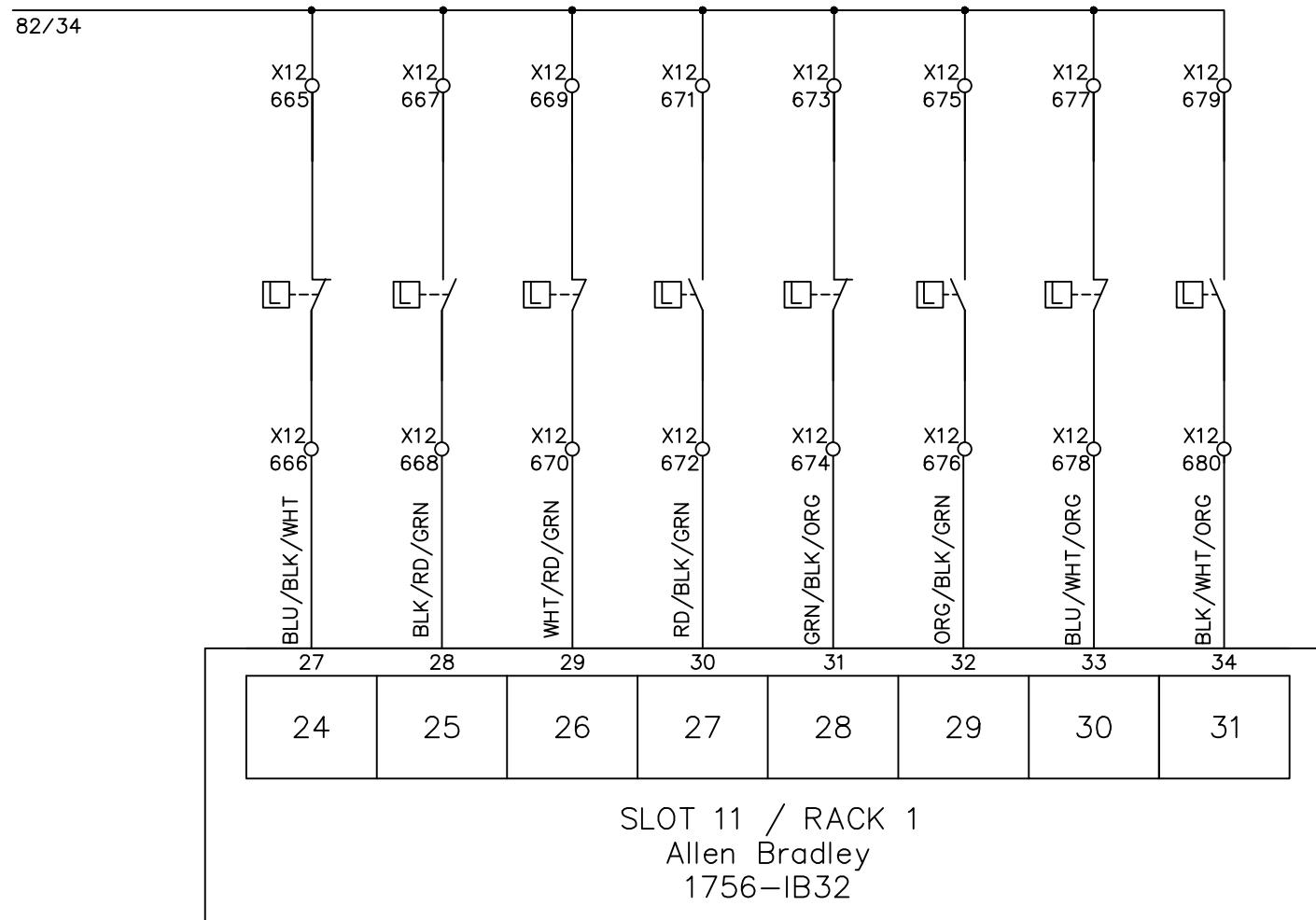
DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE
					NONE	UNIT
					MM	

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COPOLYMER SILO	COPOLYMER SILO	SAT EXT.1 HOPPER	SAT EXT.1 HOPPER	COPOLYMER SILO	COPOLYMER SILO	SAT EXT.2 HOPPER	SAT EXT.2 HOPPER
LSH1123-01	LSH1123-02	LSL1124-01	LSH1124-02	LSH1123-03	LSH1123-02	LSL1124-03	LSH1124-04



I94_8 I94_9 I94_A I94_B I94_C I94_D I94_E I94_F

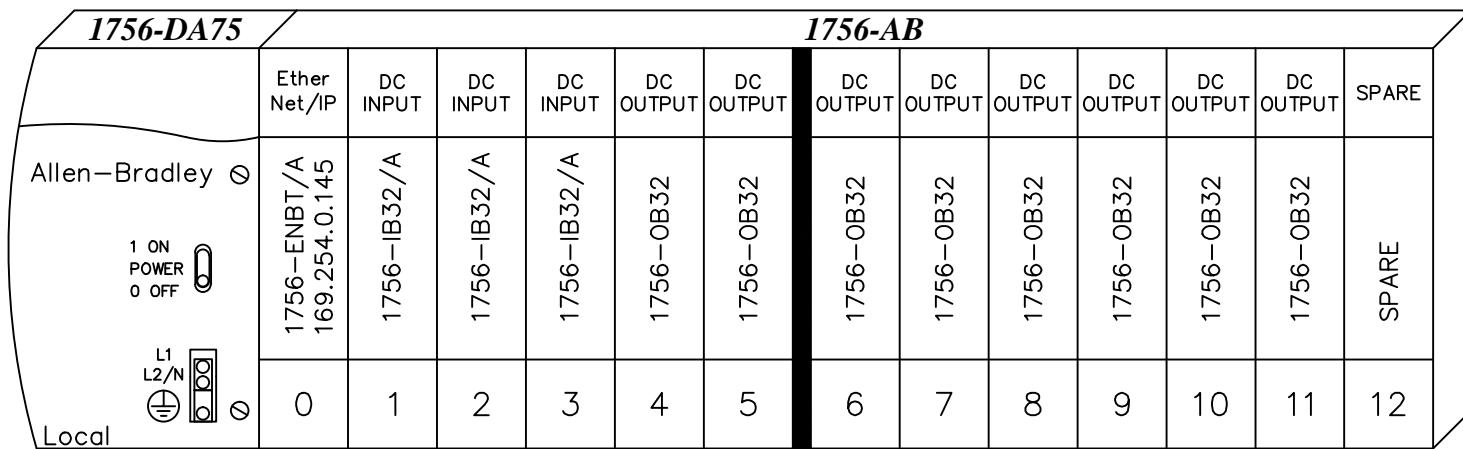
W[4943].E W[4943].D

File Name : P83 slot 11 Allen Bradley 1756-IB32 rack1-4.dwg

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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.																				DRAWING DESCRIPTION		KF023 F12 X12 DOOR 6		Page #		83												
DRAWN BY	Rufus Huang																				Total																		
CHECKED BY	JERRY WU																				MATERIAL																		
	Line4 32 P.L.C. DIGITAL INPUT										1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.						REV. NO.	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM									

01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34

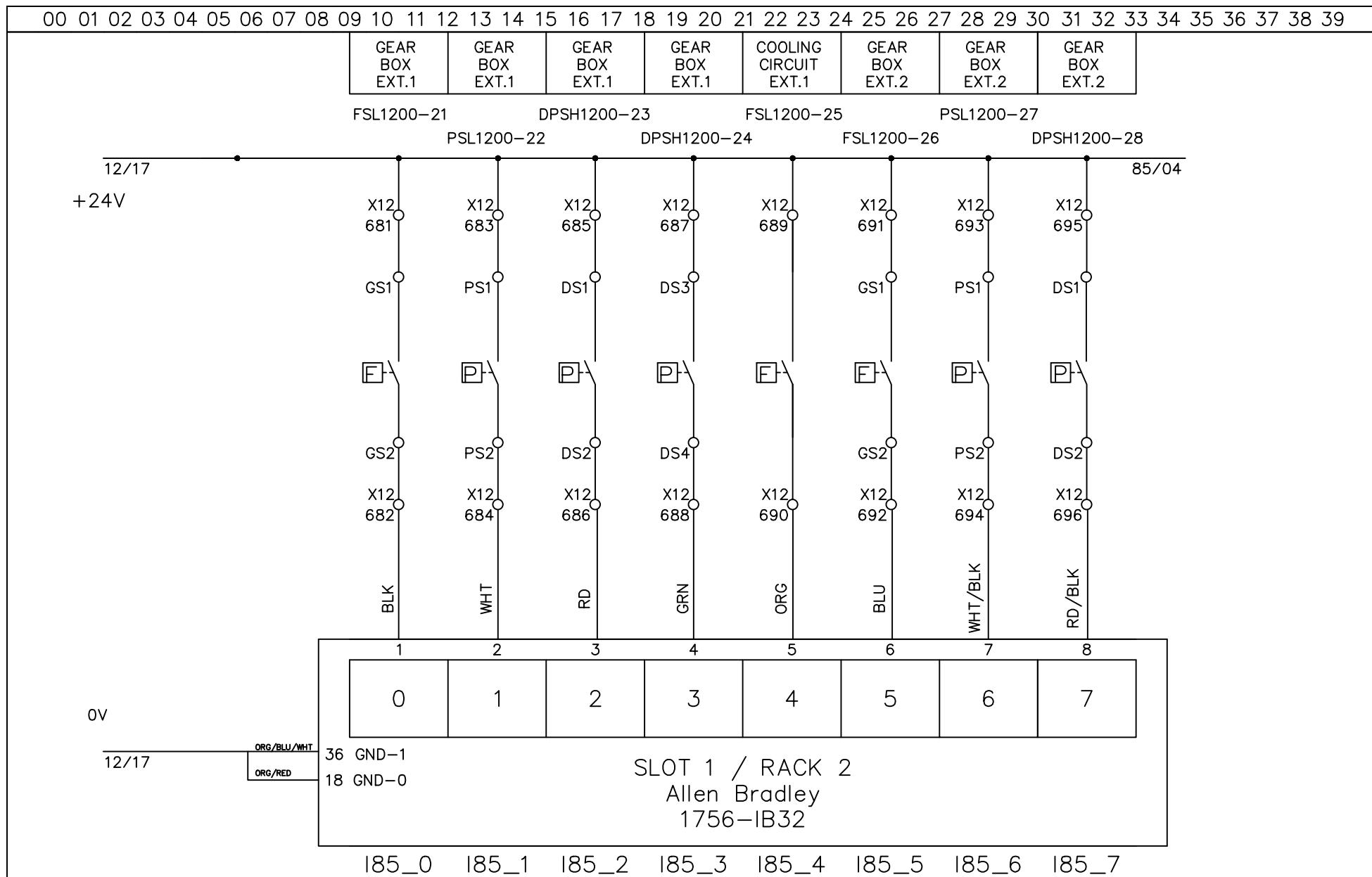
RACK 2



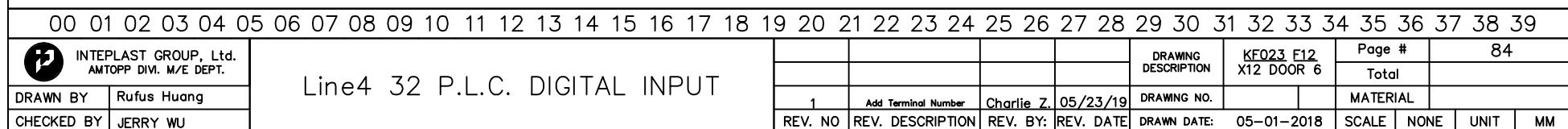
REMOTE I/O

File Name : P83-84 Rack2.dwg

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	INTEPLAST GROUP, Ltd. ANTOPP DIV. M/E DEPT.		Line4 RACK 2, 1756-A13 13-SLOT CONTROL LOGIX CHASSIS																DRAWING DESCRIPTION	KF023 E12	Page #		83-84										
DRAWN BY	Charlie Zhang																		DRAWING NO.	Total													
CHECKED BY	JERRY WU																		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM					



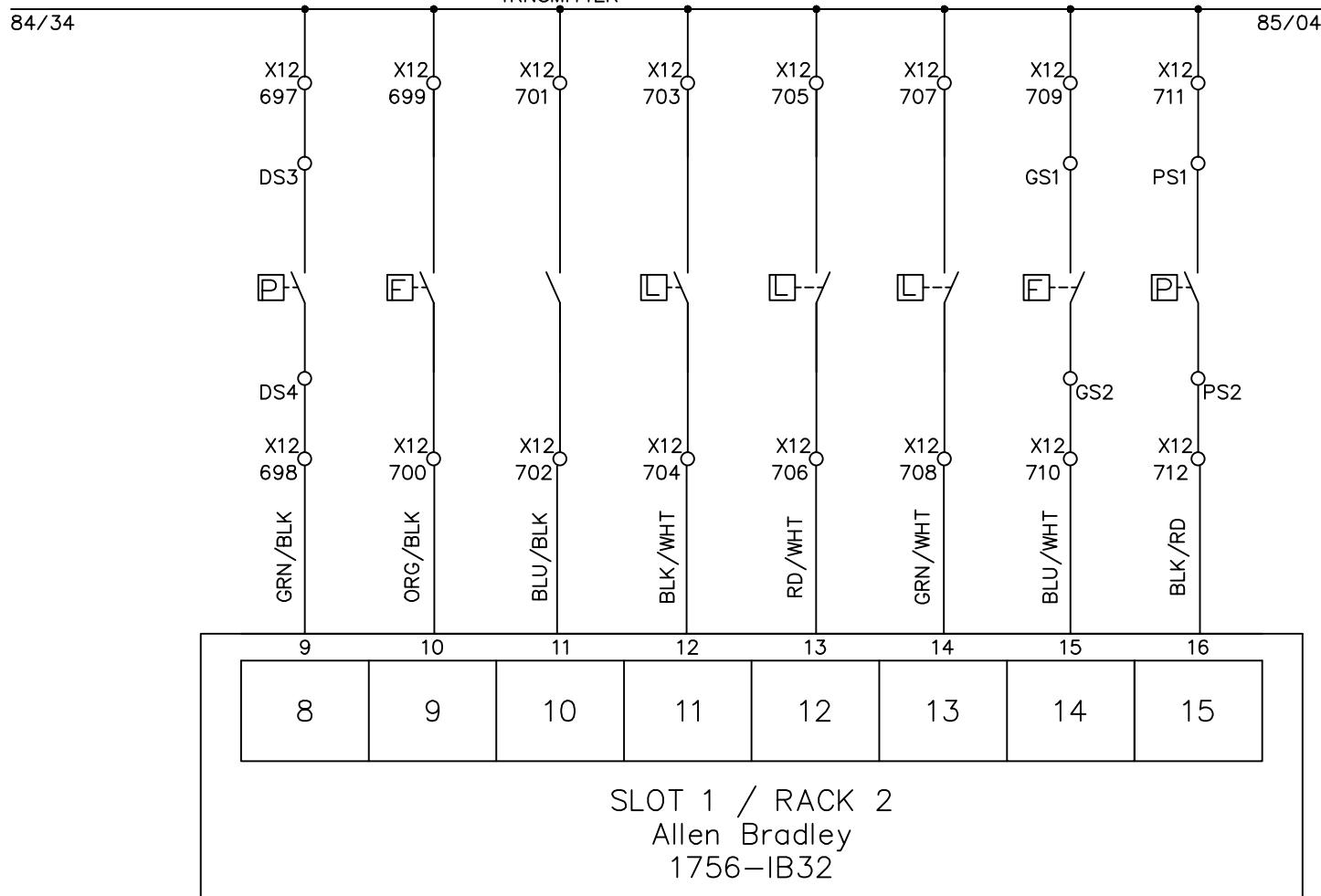
File Name : P84 slot 1 Allen Bradley 1756-IB32 rack2-1.dwg



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	GEAR BOX EXT.1	COOLING CIRCUIT EXT.2	MELT LINE AGGREGAT	ADDDITIVE	HOMO	RECLAIM	SAT. EXT.1	SAT. EXT.1
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DPSH1200 -29	FSL1200 -30	FSL1240-10 FROM TRNSMITTER	LAL1112.01	LAL1106.01	LAL1106.02	FSL1210 -35	PSL1210 -36
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185_8 185_9 185_A 185_B 185_C 185_D 185_E 185_F

W[4946].6 W[4946].5

File Name : P85 slot 1 Allen Bradley 1756-IB32 rack2-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL INPUT

DRAWING
DESCRIPTION
KF023_E12
X12 DOOR 6

Page #
85
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE
					NONE	UNIT
						MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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	GEARBOX SAT EXT.1	GEARBOX SAT EXT.1	GEARBOX SAT EXT.2	GEARBOX SAT EXT.2	GEARBOX SAT EXT.2	GEARBOX SAT EXT.2	FREE	FEEDING VALVE OPEN
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DPS1210-37

FSL1210-39

DPS1210-41

ZS01114-02

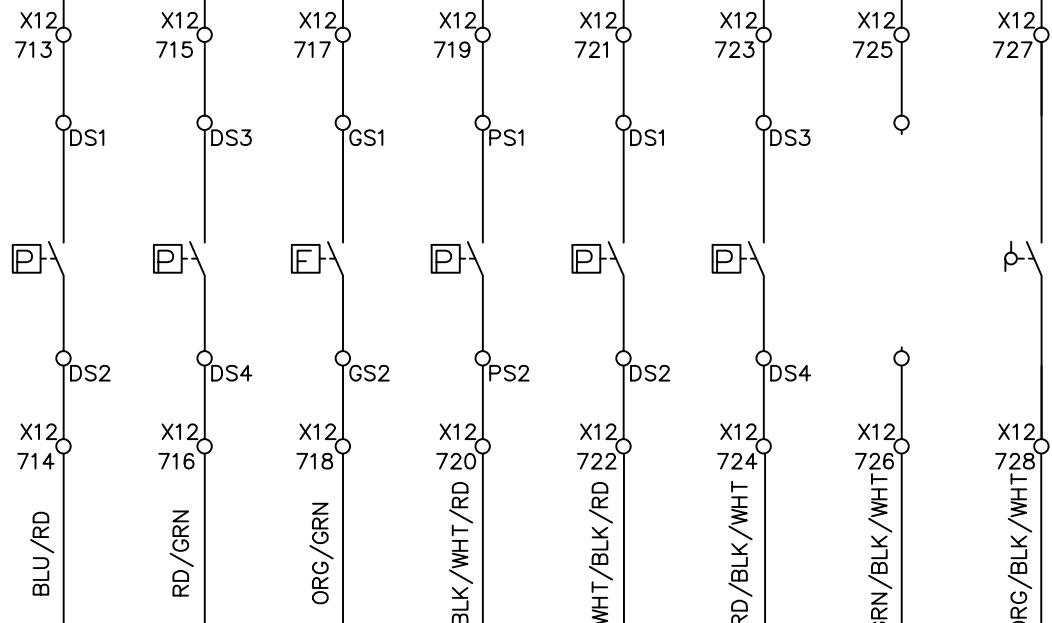
DPS1210-38

PSL1210-40

DPS1210-42

85/34

87/02



19	20	21	22	23	24	25	26
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16	17	18	19	20	21	22	23
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SLOT 1 / RACK 2
Allen Bradley
1756-IB32

I95_0 I95_1 I95_2 I95_3 I95_4 I95_5 I95_6 I95_7

W[4943].B

File Name : P86 slot 1 Allen Bradley 1756-IB32 rack2-3.dwg

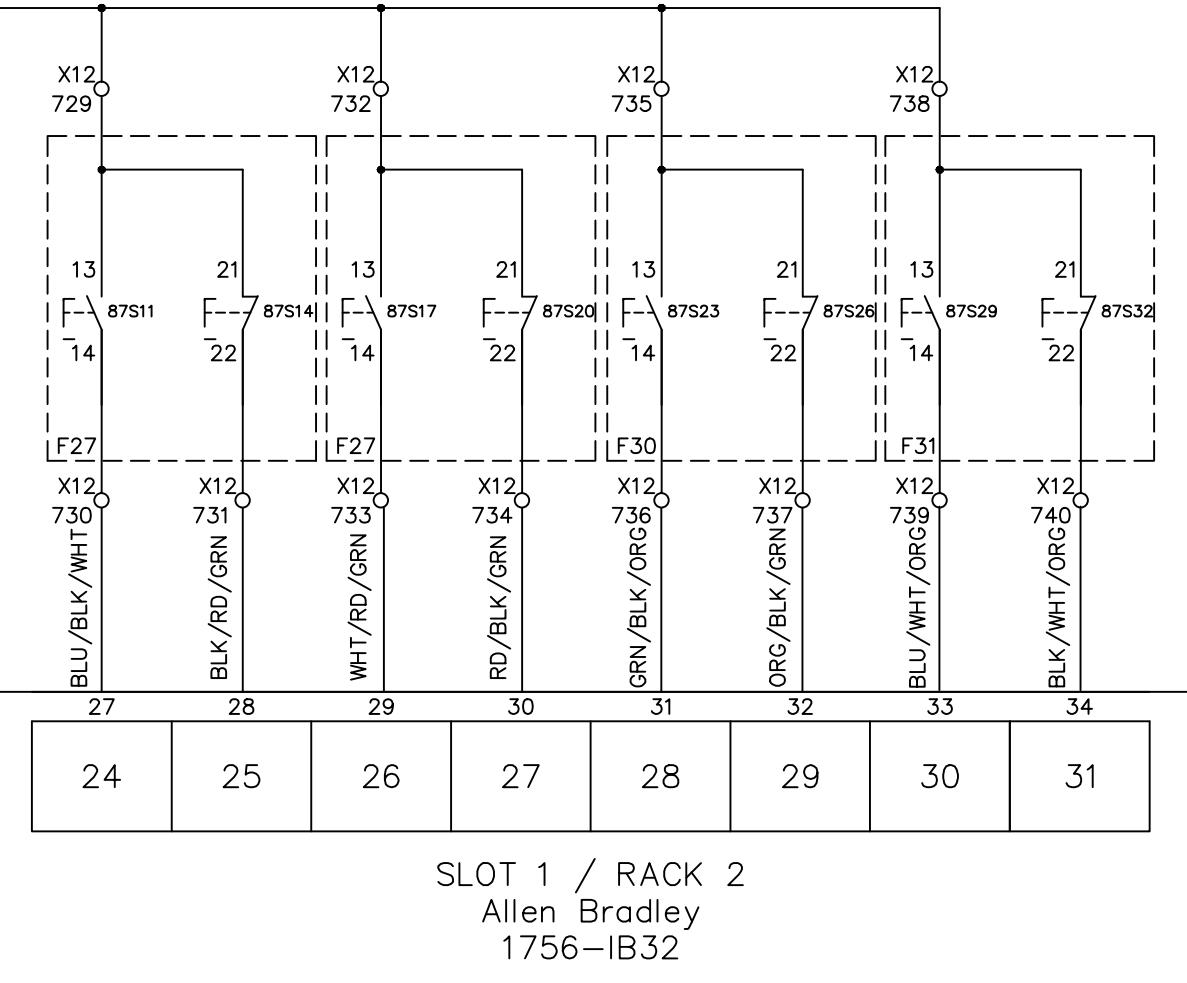
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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.	Line4 32 P.L.C. DIGITAL INPUT								DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #		86					
												Total							
DRAWN BY	Rufus Huang									MATERIAL									
CHECKED BY	JERRY WU	1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.				REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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HYDR. GROUP SAT1-START	HYDR. GROUP SAT1-STOP	HYDR. GROUP SAT2-START	HYDR. GROUP SAT2-STOP	HYDR. GROUP EXT1-START	HYDR. GROUP EXT1-STOP	HYDR. GROUP EXT2-START	HYDR. GROUP EXT2-STOP
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86/34



File Name : P87 slot 1 Allen Bradley 1756-IB32 rack2-4.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL INPUT

DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #	87
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Total

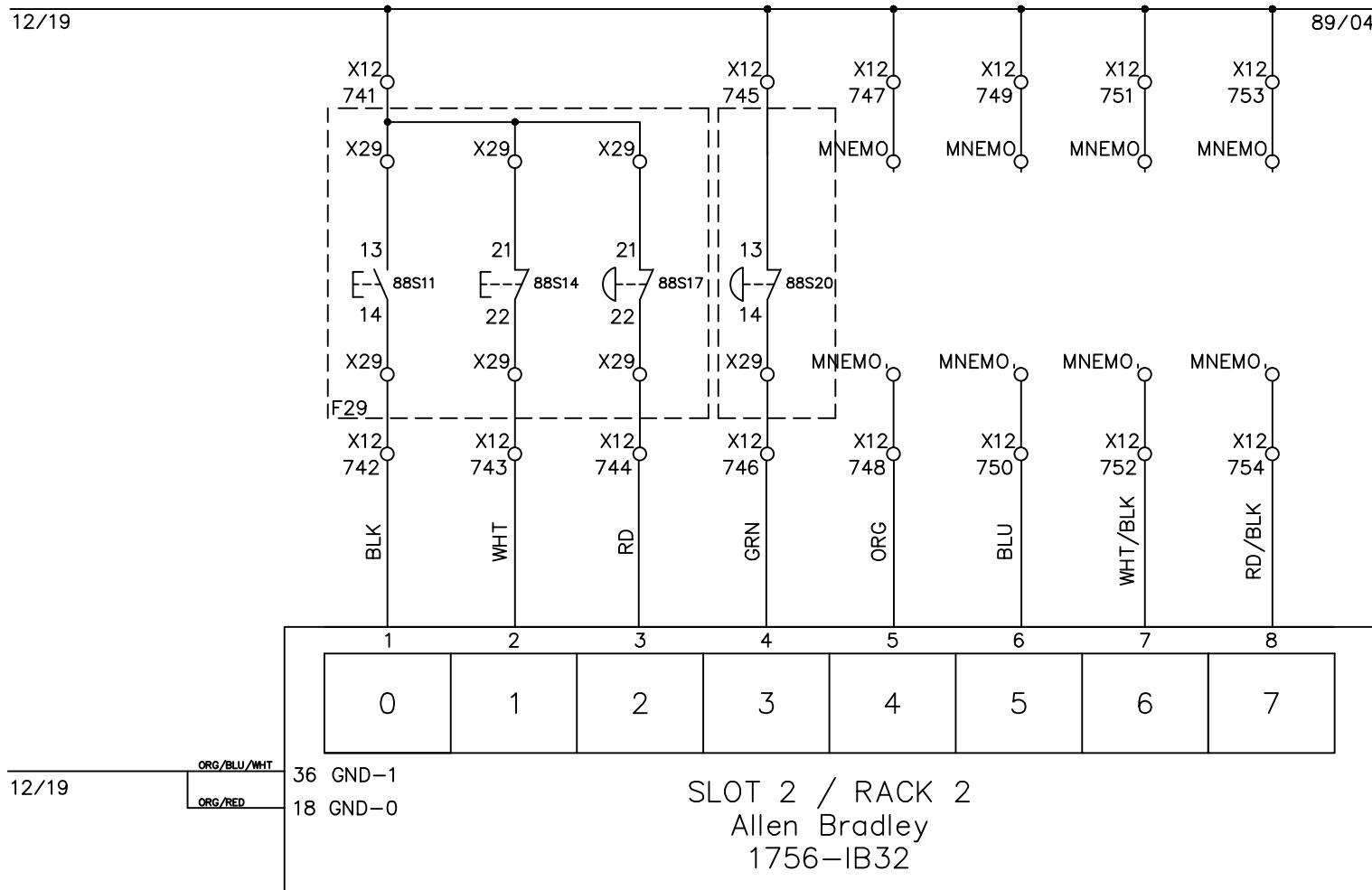
DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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	FEEDING VALVE OPEN	FEEDING VALVE CLOSE	4 EXTRUDER STOP	MELT LINE AGGREGAT STOP	FREE	FREE	FREE	FREE
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File Name : P88 slot 2 Allen Bradley 1756-IB32 rack2-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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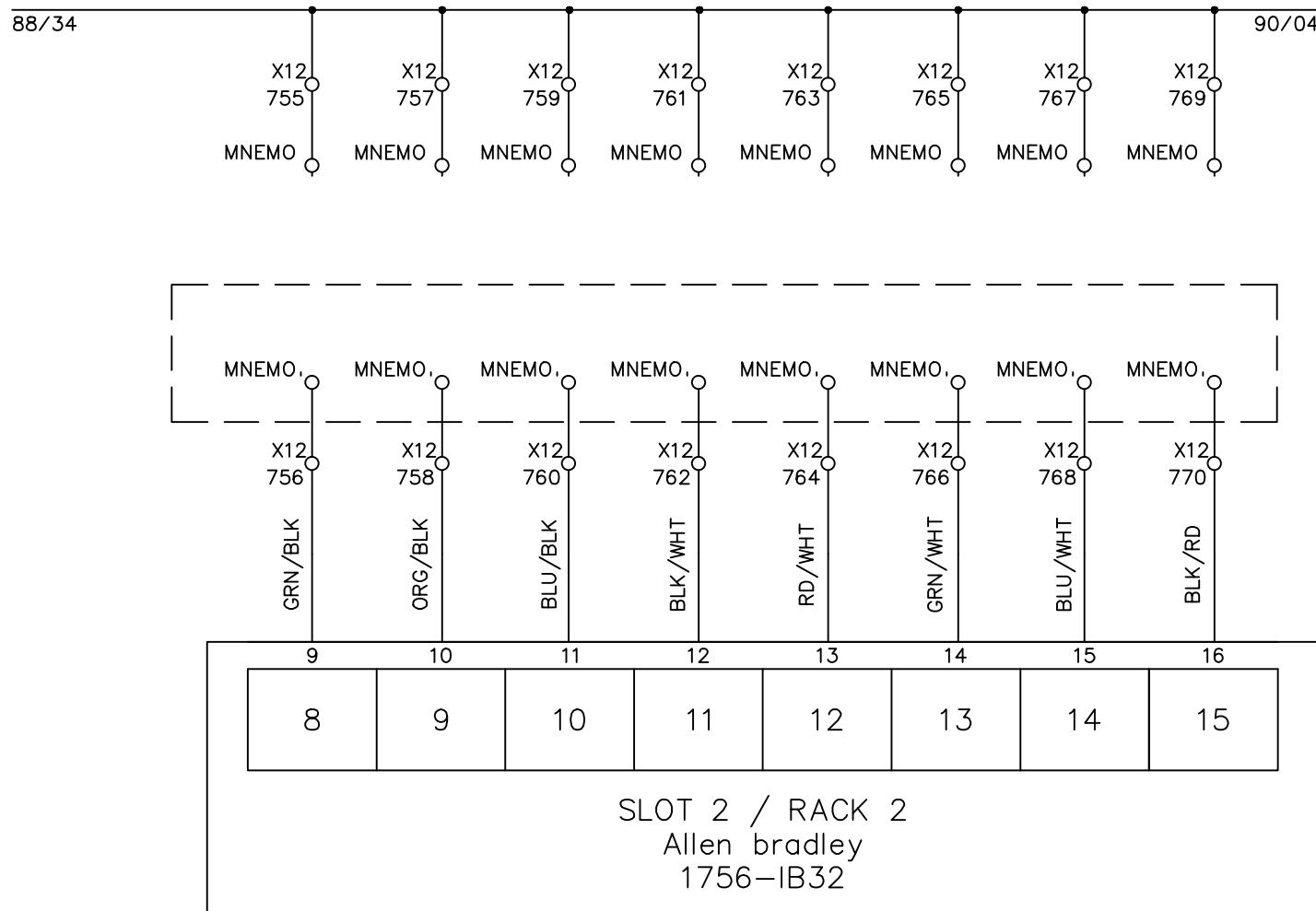


Line4 32 P.L.C. DIGITAL INPUT

DRAWN BY	Rufus Huang				DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #	88
							Total	
CHECKED BY	JERRY WU	1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL
		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE NONE UNIT MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE							
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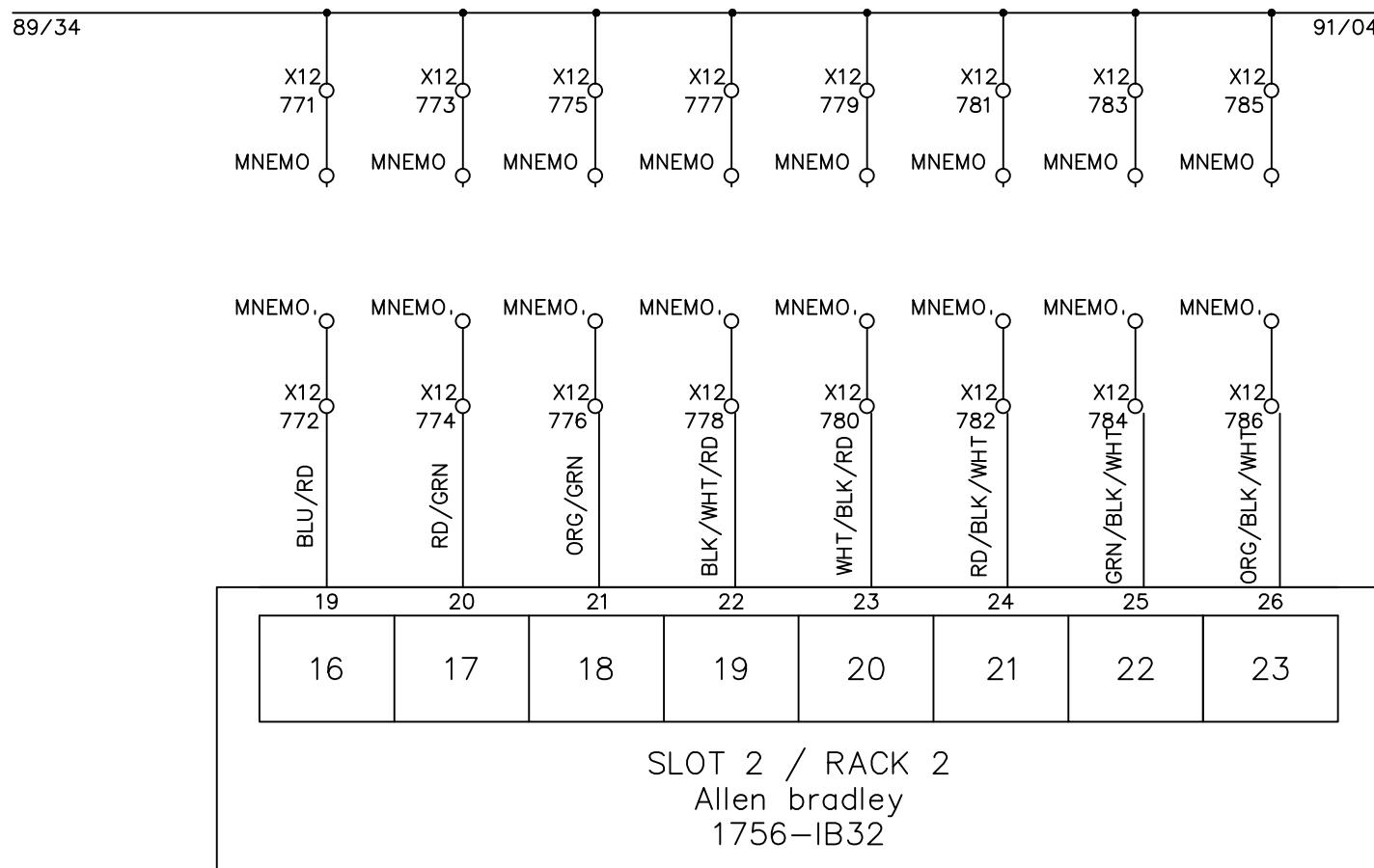
File Name : P89 slot 2 Allen Bradley 1756-IB32 rack2-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.
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Line4 AB 32 P.L.C. DIGITAL INPUT

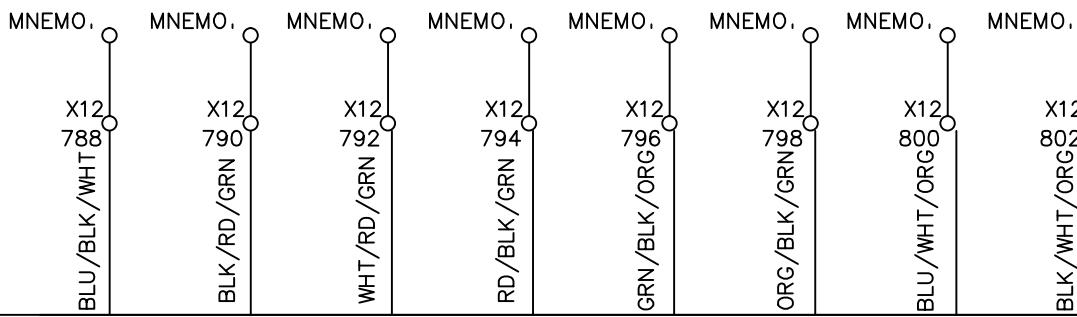
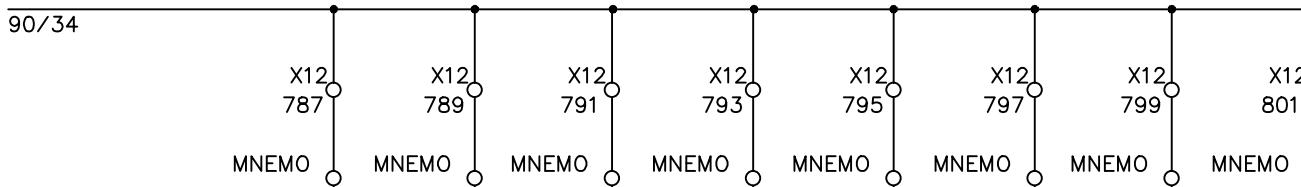
DRAWN BY	Rufus Huang				DRAWING DESCRIPTION	KF023 E12 X12 DOOR 6	Page #	
		Total	MATERIAL	UNIT			SCALE	MM
CHECKED BY	JERRY WU	1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		
		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	



File Name : P90 slot 2 Allen Bradley 1756-IB32 rack2-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE							
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27	28	29	30	31	32	33	34
24	25	26	27	28	29	30	31

SLOT 2 / RACK 2
Allen bradley
1756-IB32

196_8 196_9 196_A 196_B 196_C 196_D 196_E 196_F

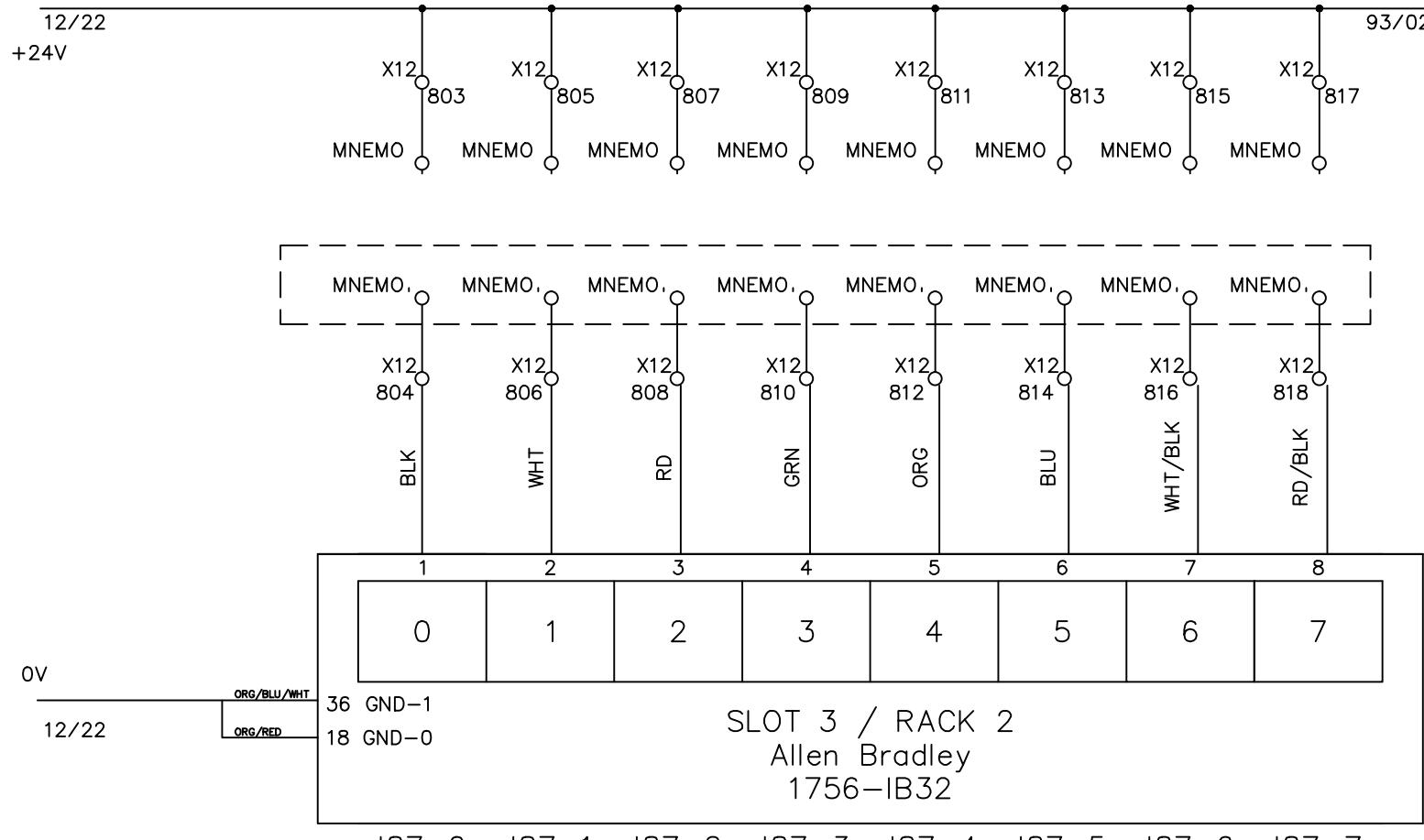
File Name : P91 slot 2 Allen Bradley 1756-IB32 rack2-4.dwg

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	Line4 32 P.L.C. DIGITAL INPUT					DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #	91		
								Total			
DRAWN BY	Rufus Huang							MATERIAL			
CHECKED BY	JERRY WU	1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		SCALE	NONE	UNIT	MM
		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018				

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE							
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File Name : P91 slot 3 Allen Bradley 1756-IB32 rack2-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL INPUT

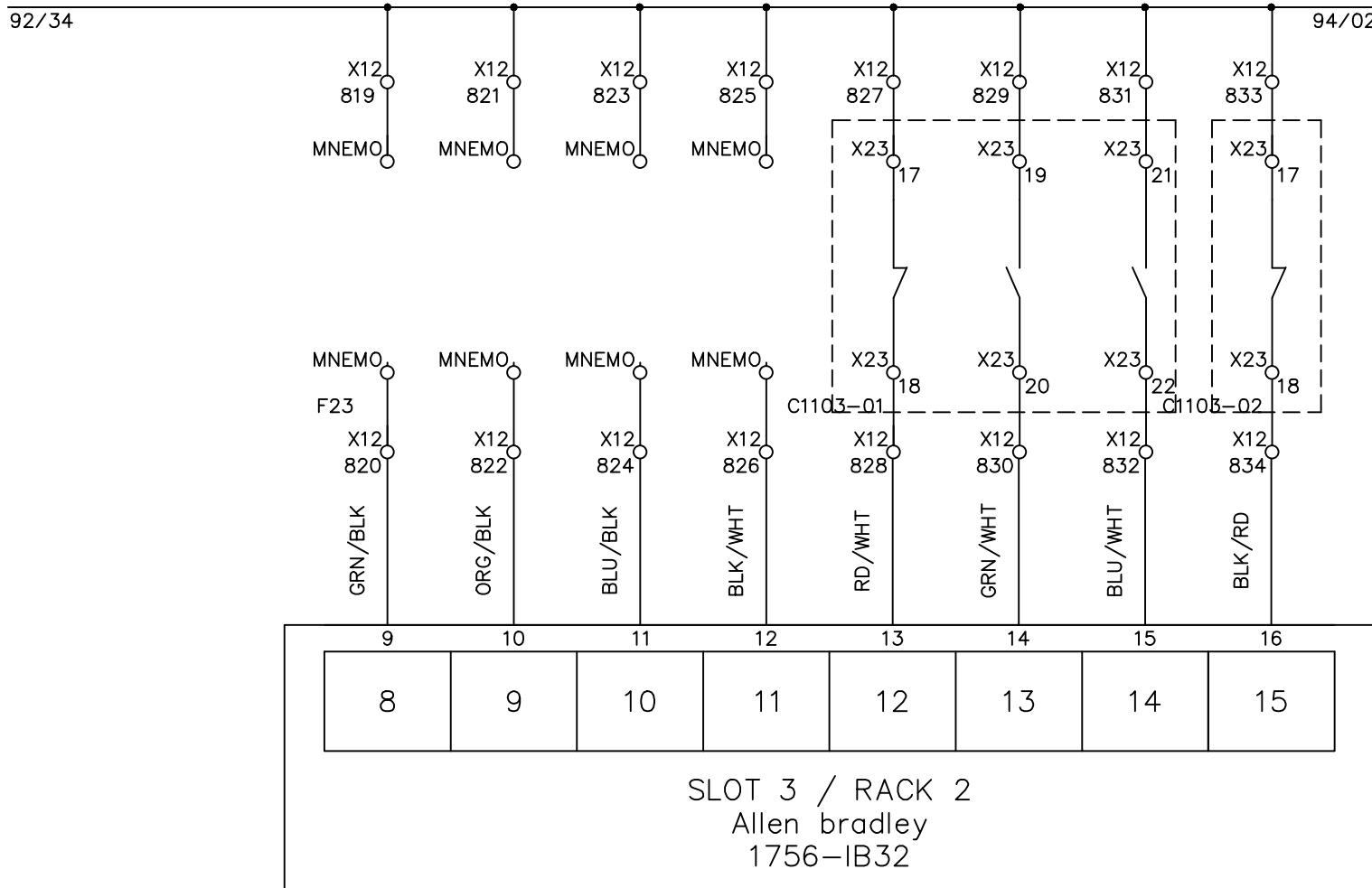
DRAWN BY	Rufus Huang				DRAWING DESCRIPTION	KF023 E12 X12 DOOR 6	Page #	92
							Total	
CHECKED BY	JERRY WU	1	Add Terminal Number	Charlie Z.	05/23/19	DRAWING NO.		MATERIAL
		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE NONE UNIT MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE	FREE	FREE	FREE	SYSTEM RUNNING	SYSTEM DEFECT	TEMPERATURE OK	SYSTEM RUNNING
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C1103-01 C1103-01 C1103-01 C1103-02

HOMO DRYER HOMO DRYER HOMO DRYER RECLAIM DRYER



File Name : P93 slot 3 Allen Bradley 1756-IB32 rack2-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

32 P.L.C. DIGITAL INPUT

			DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #	93
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Total

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DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	10/15/18	DRAWING NO.			
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REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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SYSTEM DEFECT	TEMPERATURE OK	SYSTEM RUNNING	SYSTEM DEFECT	TEMPERATURE OK	SYSTEM RUNNING	SYSTEM DEFECT	TEMPERATURE OK
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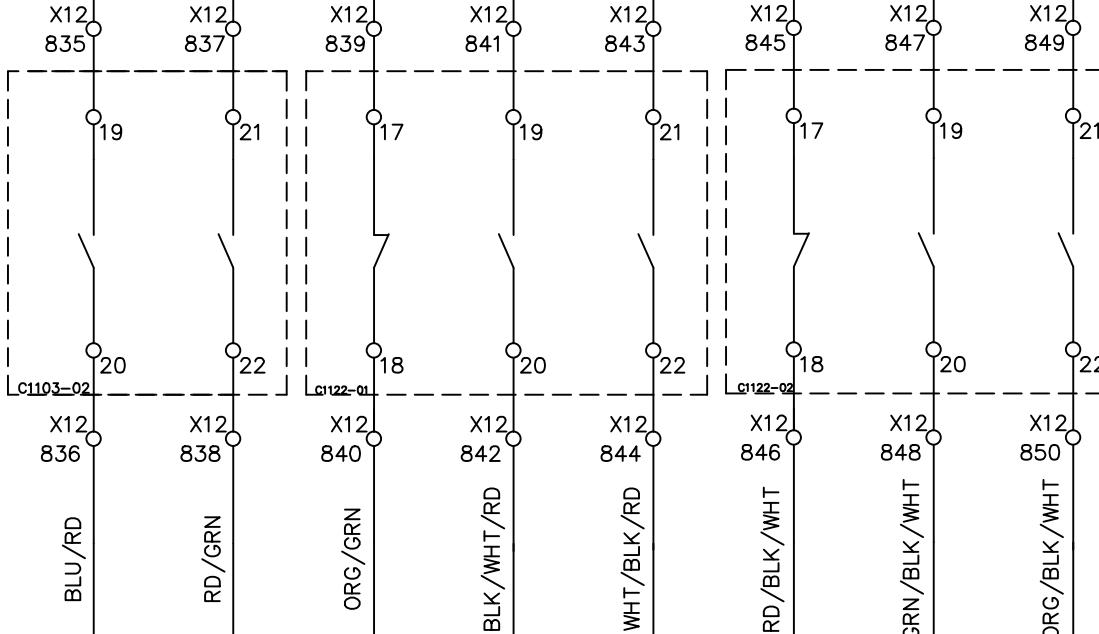
C1103-02	C1103-02	C122-01	C122-02	C122-01	C122-01	C122-01	C122-02
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RECLAIM DRYER SAT.1 DRYER SAT.1 DRYER SAT.2 DRYER SAT.2 DRYER

RECLAM DRYER SAT.1 DRYER SAT.1 DRYER SAT.2 DRYER SAT.2 DRYER

93/34

95/02



19	20	21	22	23	24	25	26
16	17	18	19	20	21	22	23

SLOT 3 / RACK 2

Allen bradley

1756-IB32

197_0 197_1 197_2 197_3 197_4 197_5 197_6 197_7

File Name : P94 slot 3 Allen Bradley 1756-IB32 rack2-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.
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Line4 AB 32 P.L.C. DIGITAL INPUT

DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #	94
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Total

DRAWN BY	Rufus Huang
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CHECKED BY	JERRY WU
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REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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1	Add Terminal Number	Charlie Z.	05/24/19
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00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE

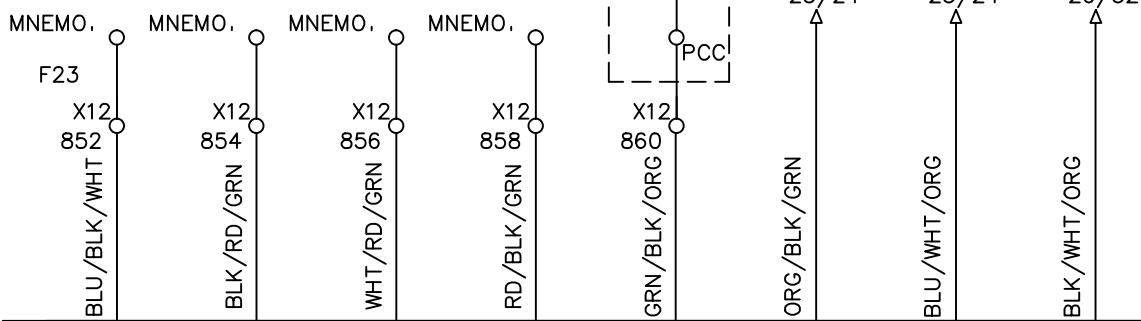
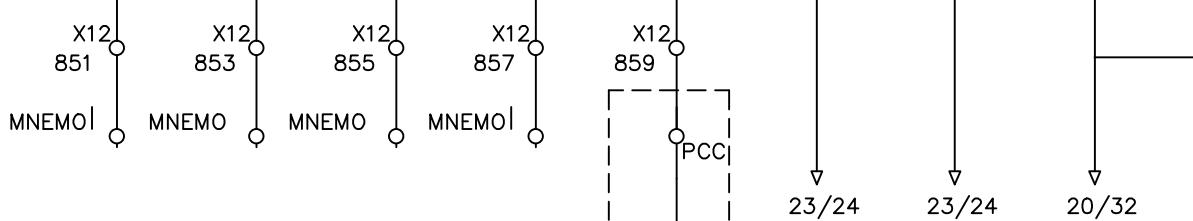
FREE

FREE

FREE

PCC
ALARMRELEASE
DEFECTRELEASE
KLAXONEMERGENCY
STOPFROM
MAIN
LOADING

94/34



24	25	26	27	28	29	30	31
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SLOT 3 / RACK 2
Allen bradley
1756-IB32

I97_8 I97_9 I97_A I97_B I97_C I97_D I97_E I97_F

File Name : P95 slot 3 Allen Bradley 1756-IB32 rack2-4.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL INPUT

KF023 F12
X12 DOOR 6

Page #
95

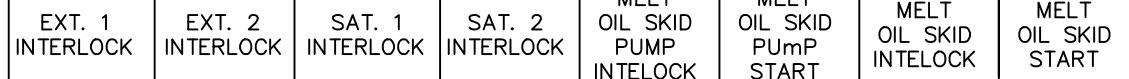
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
1	Add Terminal Number	Charlie Z.	06/03/19	DRAWING NO.		MATERIAL			

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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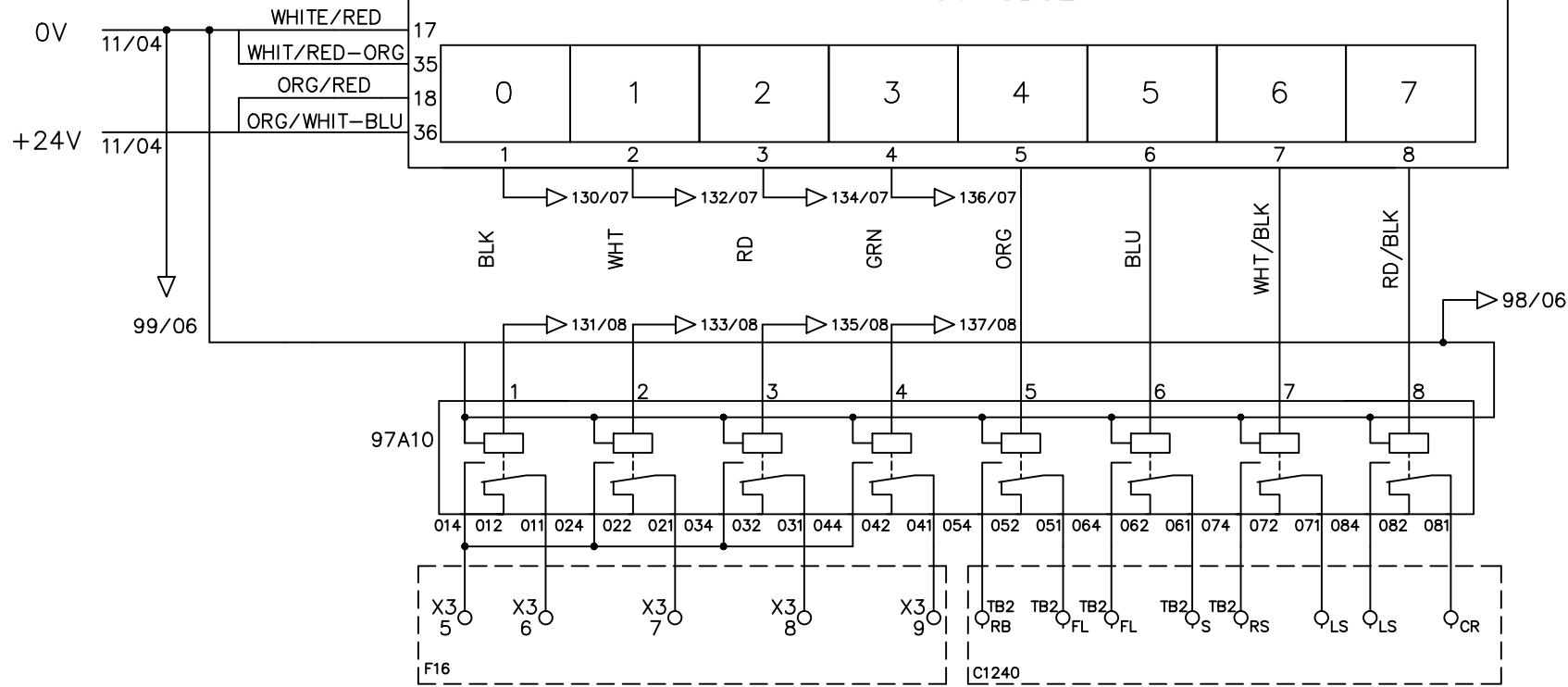


C1240 C1240 C1240 C1240

W[4947].2 W[4947].3 W[4947].0 W[4947].1

OA0_0 OA0_1 OA0_2 OA0_3 OA0_4 OA0_5 OA0_6 OA0_7

SLOT 4 / RACK 2
Allen Bradley
1756-OB32



File Name: P97 Slot 4 Allen Bradley 1756-OB32 Rack-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023
F12

Page #
97
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	06/03/19	DRAWING NO.		MATERIAL
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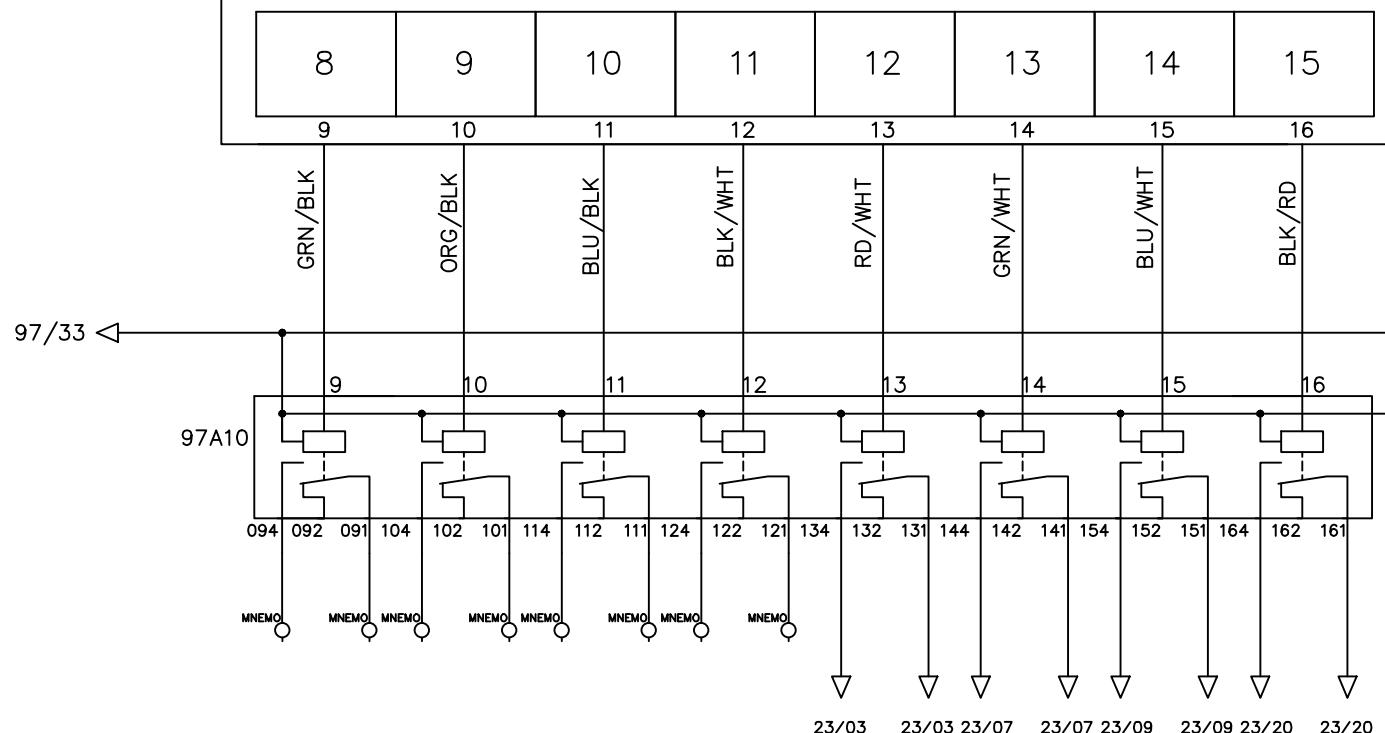
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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	FREE	FREE	FREE	FREE	KLAXON	ROTATING LIGHT	RELEASE KLAXON	RELEASE DEFECT	
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W[4621].E W[4621].D

OAO_8 OAO_9 OAO_A OAO_B OAO_C OAO_D OAO_E OAO_F

SLOT 4 / RACK 2
Allen Bradley
1756-OB32



File Name: P98 slot 4 Allen Bradley 1756-OB32 rack2-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE	FREE	DRIVE INTERLOCK AUGER 2	START/STOP COMMAND AUGER 2	DRIVE INTERLOCK AUGER 3	START/STOP COMMAND AUGER 3	DRIVE INTERLOCK AUGER 1	START/STOP COMMAND AUGER 1
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M1106-01	M1106-01	M1106-02	M1106-02	M1112-01	M1112-01
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W[4925].3

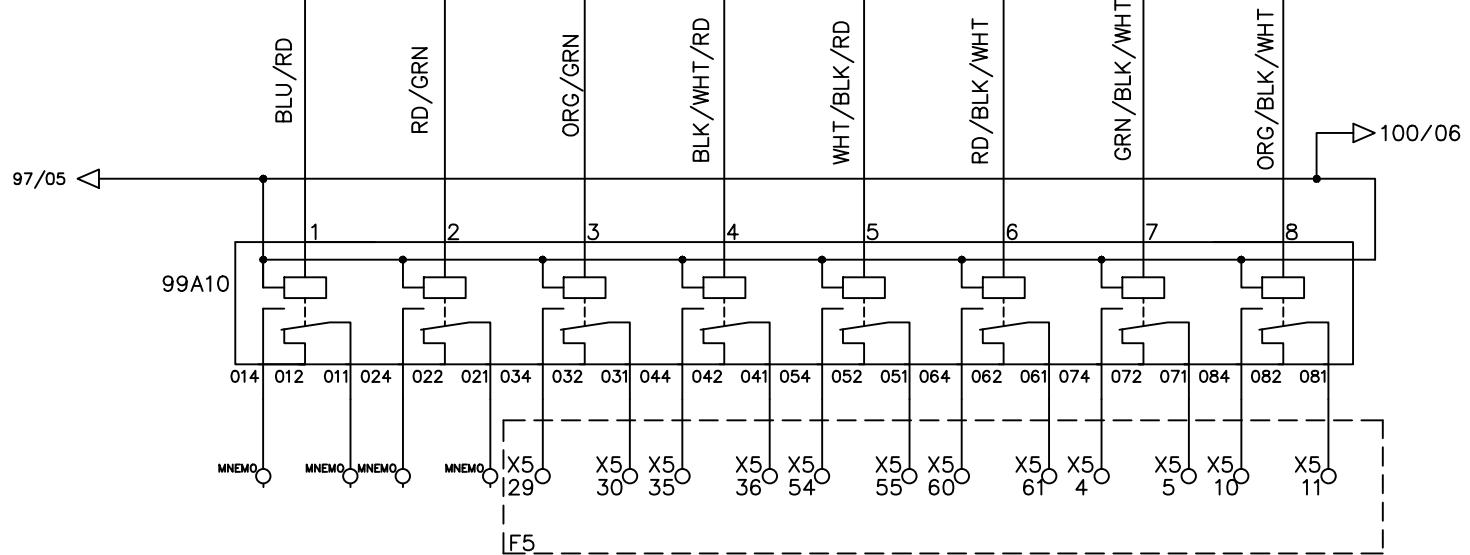
W[4925].2

W[4925].4

OB0_0 OB0_1 OB0_2 OB0_3 OB0_4 OB0_5 OB0_6 OB0_7

SLOT 4 / RACK 2
Allen Bradley
1756-OB32

16	17	18	19	20	21	22	23
19	20	21	22	23	24	25	26



File Name : P99 slot 4 Allen Bradley 1756-OB32 rack2-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.																												DRAWING DESCRIPTION	KF023 F12	Page #	99							
DRAWN BY	Rufus Huang																												Total										
CHECKED BY	JERRY WU																												MATERIAL										
																													REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM	

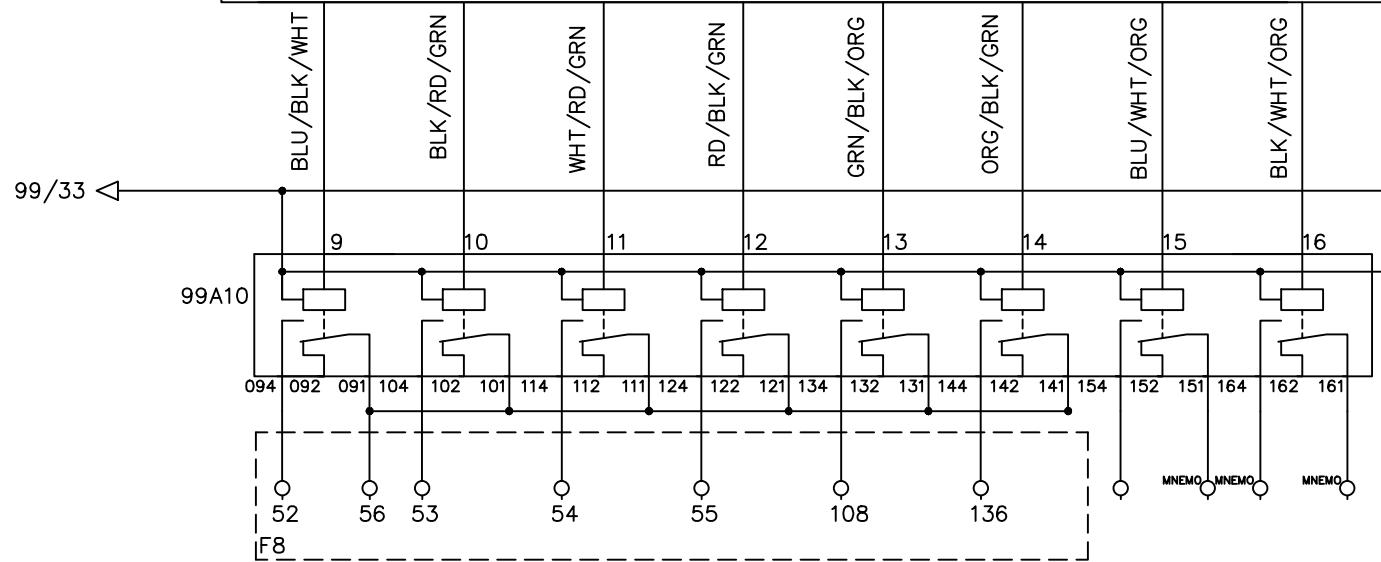
00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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RUN MOTOR 1	RUN MOTOR 2	RUN MOTOR 3	RUN MOTOR 4	RUN MOTOR 5	RUN MOTOR 6	FREE	FREE
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OB0_8 OB0_9 OB0_A OB0_B OB0_C OB0_D OB0_E OB0_F

SLOT 4 / RACK 2
Allen Bradley
1756-OB32

24	25	26	27	28	29	30	31
27	28	29	30	31	32	33	34



File Name : P100 slot 4 Allen Bradley 1756-OB32 rack2-4.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023
F12

Page #
100
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	06/03/19	DRAWING NO.		MATERIAL
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE
					NONE	UNIT
					MM	

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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	HEATER ZONE 1 EXT. 1	HEATER ZONE 2 EXT. 1	HEATER ZONE 3 EXT. 1	HEATER ZONE 4 EXT. 1	COOLING PUMP EXT. 1	MIXING SCREU	ROTARY ARM	HEATER ZONE 1 EXT. 2
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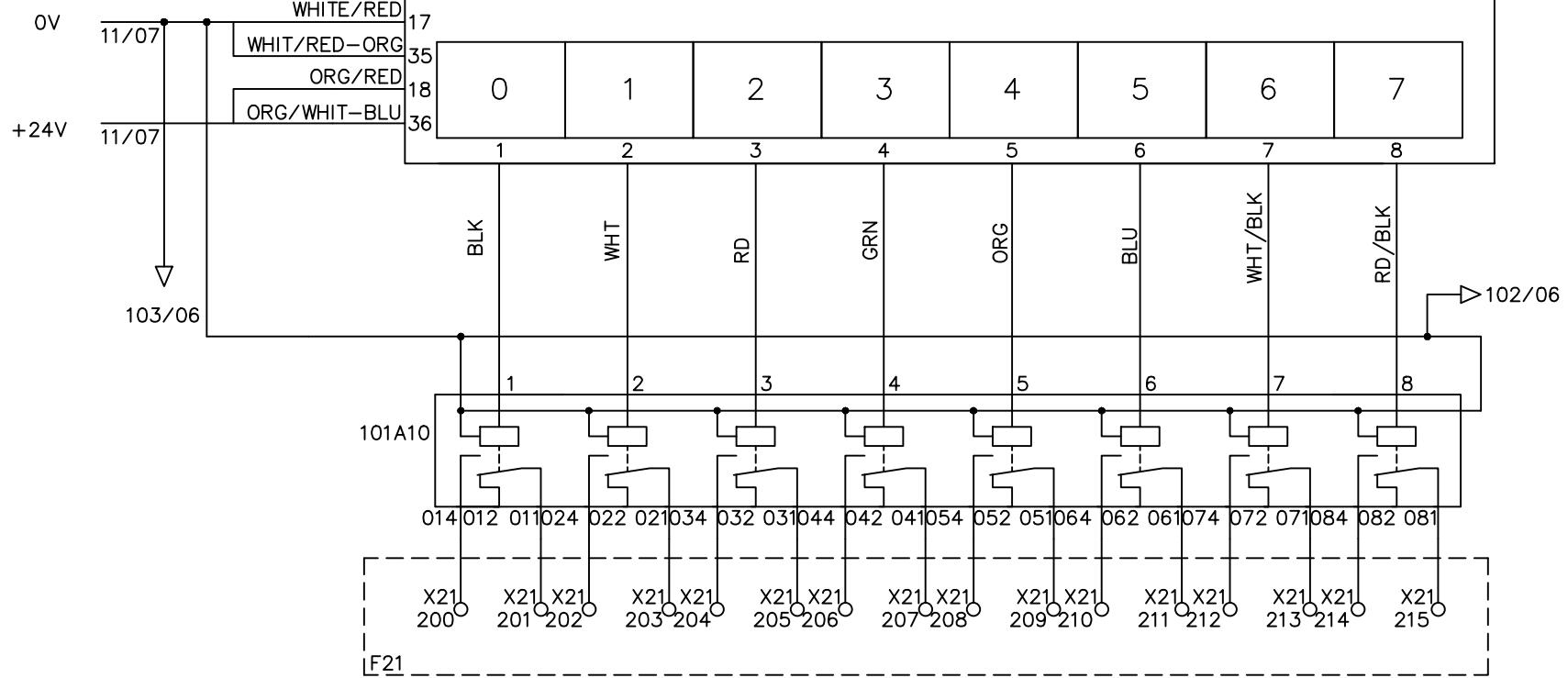
H1200-01 H1200-02 H1200-03 H1200-04 M1200-05 M1114-01 M1114-02 H1200-06

W[511].4 W[511].5 W[511].6 W[511].7 W[511].C W[515].5 W[515].6 W[512].8

OA1_0 OA1_1 OA1_2 OA1_3 OA1_4 OA1_5 OA1_6 OA1_7

SLOT 5 / RACK 2

Allen Bradley
1756-OB32



File Name: P101 slot 5 Allen Bradley 1756-OB32 rack2-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023
F12

Page #
101
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	06/03/19	DRAWING NO.		MATERIAL
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REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

HEATER ZONE 2 EXT. 2	HEATER ZONE 3 EXT. 2	HEATER ZONE 4 EXT. 2	COOLING PUMP EXT. 2	ADDITIVE VACUUM PUMP	SIGNAL TO F13/WATER BATH THAT SEL. EXT. RUNNING	MELT LINE 1 ZONE 1	MELT LINE 1 ZONE 2
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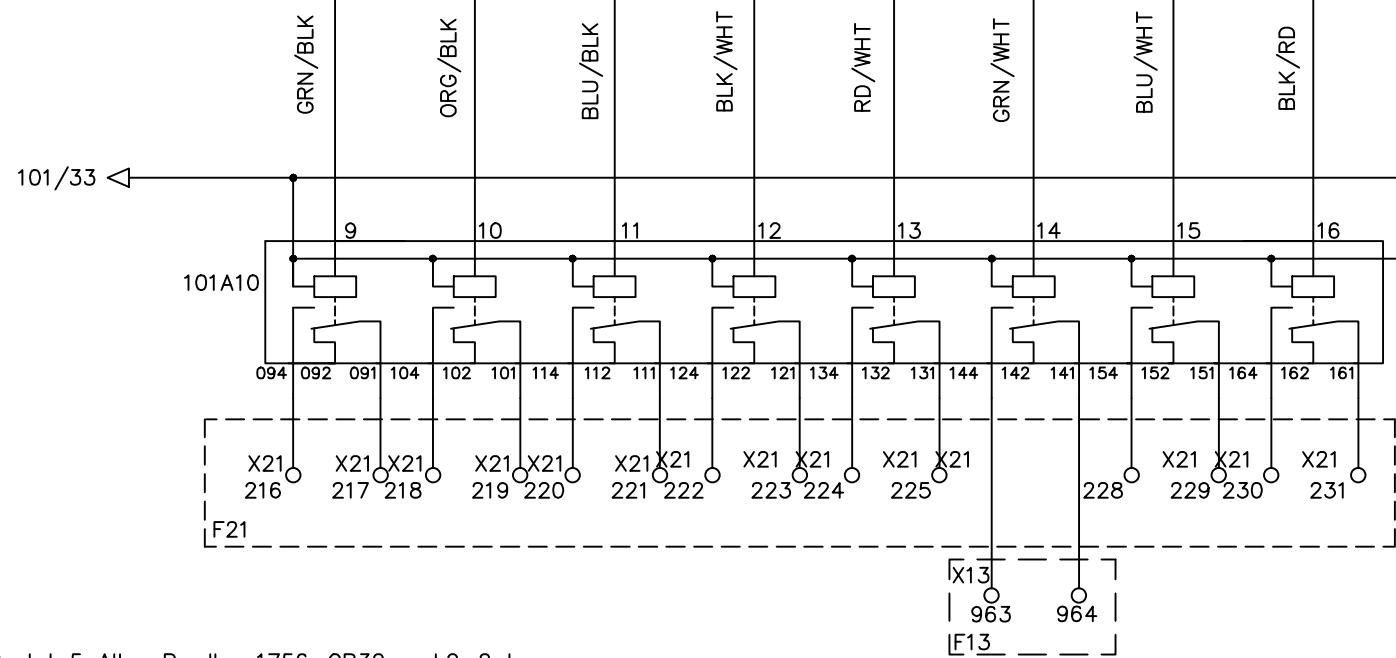
H1200-07 H1200-08 H1200-09 M1200-11 M1107-01 H1200-12 H1200-13

W[512].9 W[512].A W[512].B W[513].0 W[511].E W[511].F

OA1_8 OA1_9 OA1_A OA1_B OA1_C OA1_D OA1_E OA1_F

SLOT 5 / RACK 2
Allen Bradley
1756-OB32

8	9	10	11	12	13	14	15
9	10	11	12	13	14	15	16



File Name : P102 slot 5 Allen Bradley 1756-OB32 rack2-2.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING DESCRIPTION KF023
F12

Page # 102
Total

DRAWN BY Rufus Huang

CHECKED BY Jerry Wu

1	Add Terminal Number	Charlie Z.	06/03/19	DRAWING NO.		MATERIAL
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE NONE UNIT MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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MELT LINE 1 ZONE 3	MELT LINE 1 ZONE 4	FREE	FREE	MOTOR CHANGE FILTER EXT. 1	FILTER ZONE 1	FILTER ZONE 2	FILTER ZONE 3
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H1200-14 H1200-15

M1230-01 H1230-02 H1230-03 H1230-04

W[512].0 W[512].1

W[517].2 W[511].9 W[511].A W[511].B

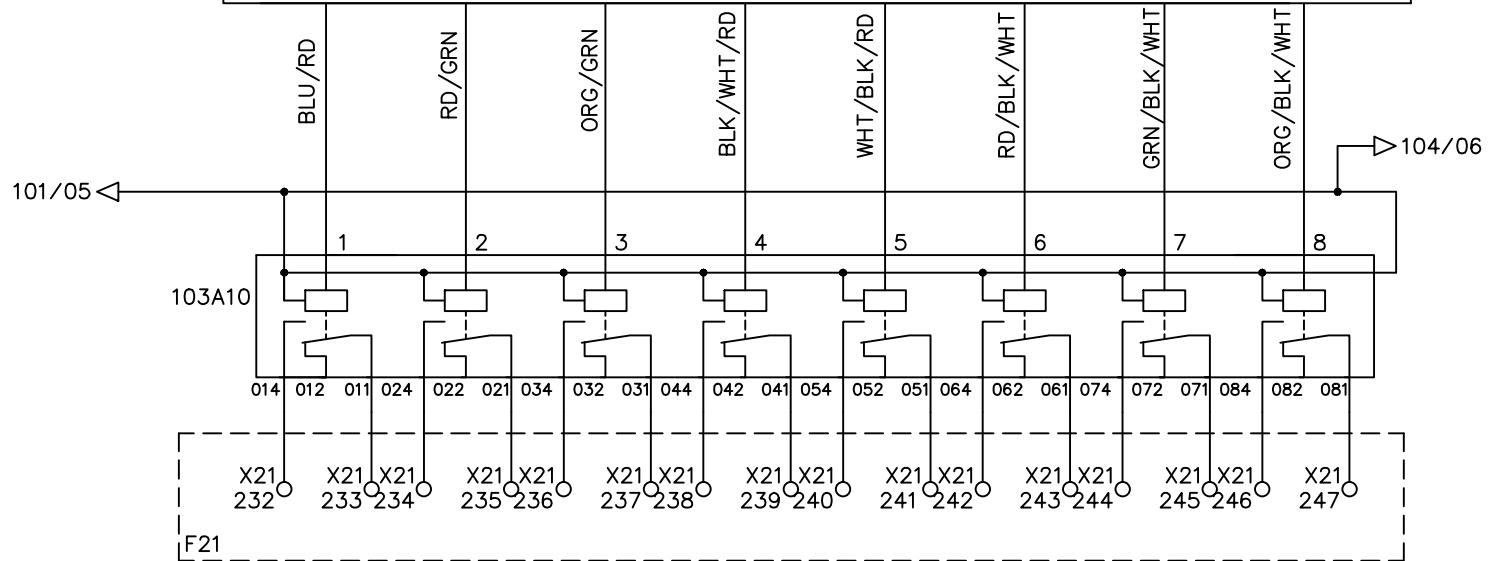
OB1_0 OB1_1 OB1_2 OB1_3 OB1_4 OB1_5 OB1_6 OB1_7

SLOT 5 / RACK 2

Allen Bradley
1756-OB32

16	17	18	19	20	21	22	23
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19	20	21	22	23	24	25	26
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File Name : P103 slot 5 Allen Bradley 1756-OB32 rack2-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

KF023
F12

Page #
103

Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
1	Add Terminal Number	Charlie Z.	06/03/19	DRAWING NO.		MATERIAL			

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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ADAPTER	FREE	FREE	MOTOR CHANGE FILTER EXT. 2	FILTER ZONE 1	FILTER ZONE 2	FILTER ZONE 3	ADAPTER
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H1230-05

M1231-01

H1231-02

H1231-03

H1231-04

H1231-05

W[511].8

W[517].3

W[512].D

W[512].E

W[512].F

W[512].C

OB1_8

OB1_9

OB1_A

OB1_B

OB1_C

OB1_D

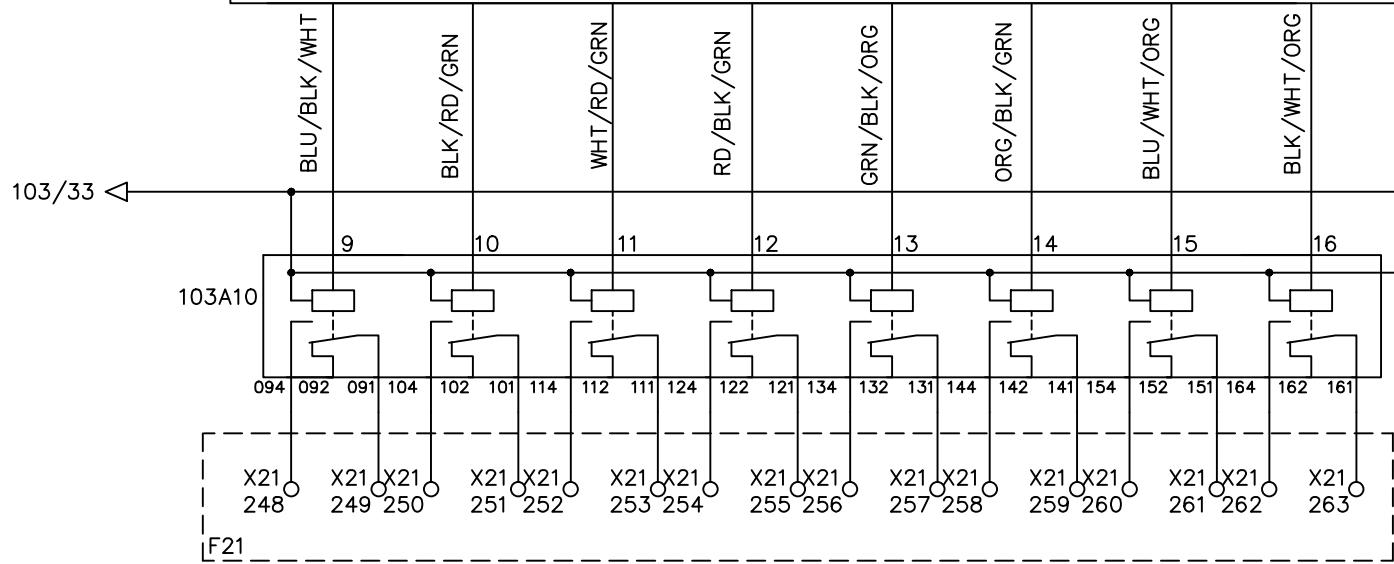
OB1_E

OB1_F

SLOT 5 / RACK 2

Allen Bradley
1756-OB32

24	25	26	27	28	29	30	31	32	33	34
27	28	29	30	31	32	33	34			



File Name : P104 slot 5 Allen Bradley 1756-OB32 rack2-4.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
	INTEPLAST GROUP, Ltd.	AMTOPP DIV. M/E DEPT.																										DRAWING DESCRIPTION	KF023	Page #	104								
DRAWN BY	Rufus Huang																											Total											
CHECKED BY	JERRY WU																											MATERIAL											
																												REV. NO.	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM		

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

SAT. EXT. 1 HEATER Z1	SAT. EXT. 1 HEATER Z2	SAT. EXT. 1 HEATER Z3	SAT. EXT. 1 HEATER Z4	SAT. EXT. 1 HEATER Z5	SAT. EXT. 1 HEATER Z6	SAT. EXT. 1 HEATER Z7	ADAPTER SAT. EXT. 1
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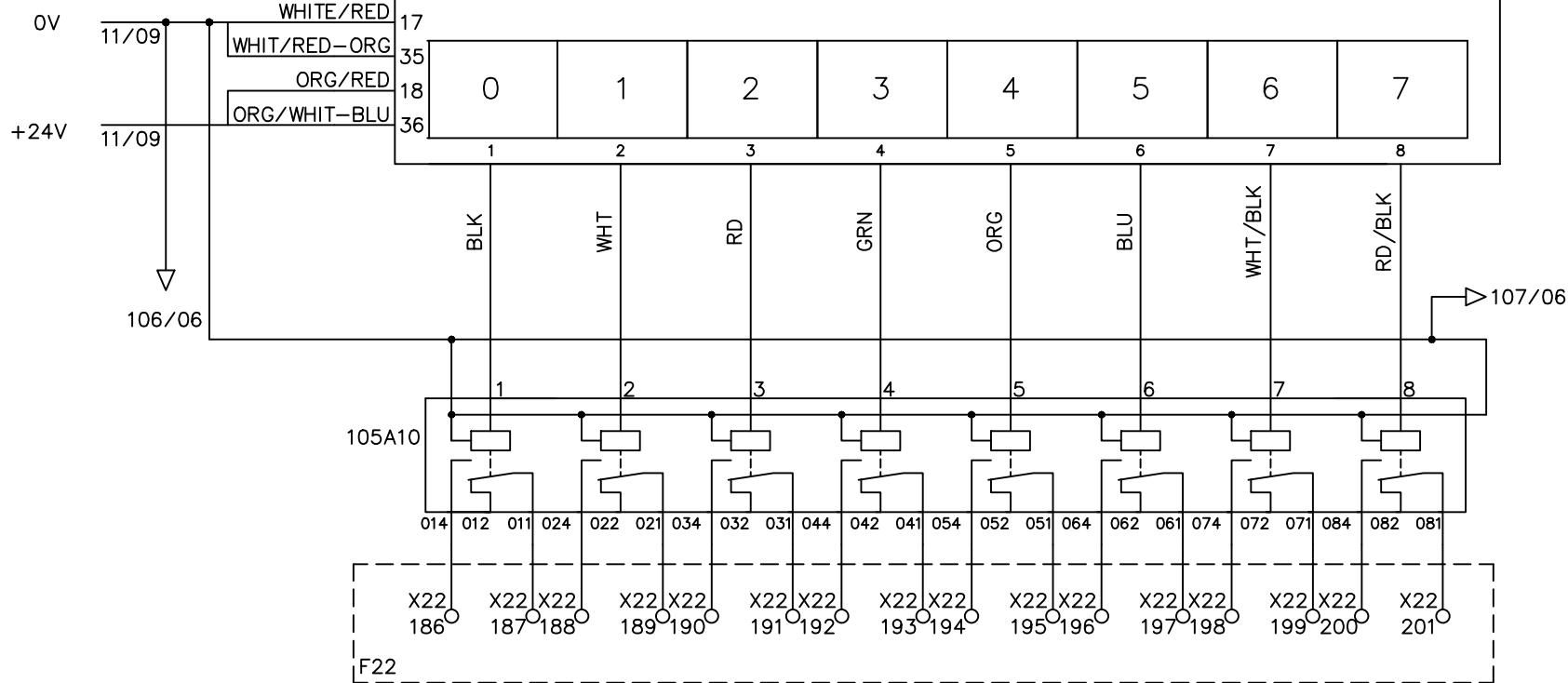
H1210-01 H1210-02 H1210-03 H1210-04 H1210-05 H1210-06 H1210-07 H1210-29

W[510].0 W[510].1 W[510].2 W[510].3 W[510].4 W[510].5 W[510].6 W[510].7

OA2_0 OA2_1 OA2_2 OA2_3 OA2_4 OA2_5 OA2_6 OA2_7

SLOT 6 / RACK 2

Allen Bradley
1756-OB32



File Name : P105 slot 6 Allen Bradley 1756-OB32 rack2-1.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023
F12

Page #
105
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
1	Charlie Z.	06/04/19							

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COOLING FAN Z1	COOLING FAN Z2	COOLING FAN Z3	COOLING FAN Z4	COOLING FAN Z5	COOLING FAN Z6	COOLING FAN Z7	FREE
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H1210-08 H1210-09 H1210-10 H1210-11 H1210-12 H1210-13 H1210-14

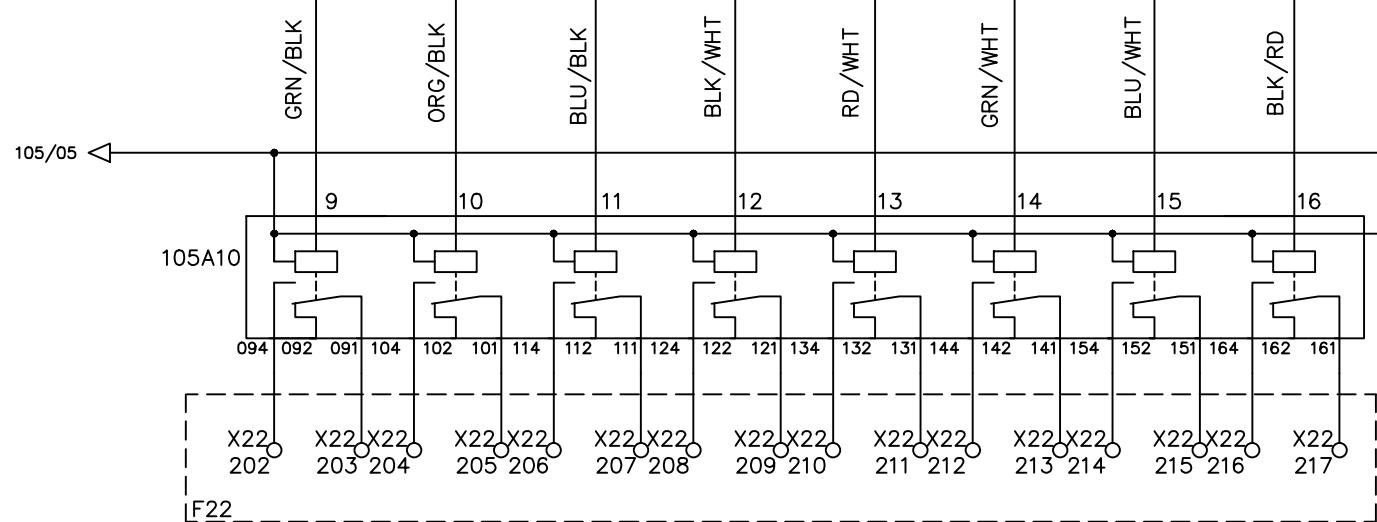
W[518].0 W[518].1 W[518].2 W[518].3 W[518].4 W[518].5 W[518].6

OA2_8 OA2_9 OA2_A OA2_B OA2_C OA2_D OA2_E OA2_F

SLOT 6 / RACK 2

Allen Bradley
1756-OB32

8	9	10	11	12	13	14	15
9	10	11	12	13	14	15	16



File Name : P106 slot 6 Allen Bradley 1756-OB32 rack2-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING DESCRIPTION
KF023 F12

Page #
106

Total

DRAWN BY

Perrick Hsiao

CHECKED BY

JERRY WU

1	Add Terminal Number	Charlie Z.	06/04/19	DRAWING NO.		MATERIAL
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REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	03-23-2015	SCALE	NONE	UNIT	MM
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File Name : P107 slot 6 Allen Bradley 1756-OB32 Rack2-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39		
	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.																				DRAWING DESCRIPTION		KF023 F12		Page #		107														
DRAWN BY	Perrick Hsiao																				Total																				
CHECKED BY	JERRY WU																				MATERIAL																				
Line4 32 P.L.C. DIGITAL OUTPUT										1		Add Terminal Number		Charlie Z.		06/04/19		DRAWING NO.				REV. NO		REV. DESCRIPTION		REV. BY:		REV. DATE		DRAWN DATE:		03-23-2015		SCALE		NONE		UNIT		MM	

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

ADAPTER SAT. EXT. 2	COOLING FAN Z1	COOLING FAN Z2	COOLING FAN Z3	COOLING FAN Z4	COOLING FAN Z5	COOLING FAN Z6	COOLING FAN Z7
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H1210-30 M1210-22 M1210-23 M1210-24 M1210-25 M1210-26 M1210-27 M1210-28

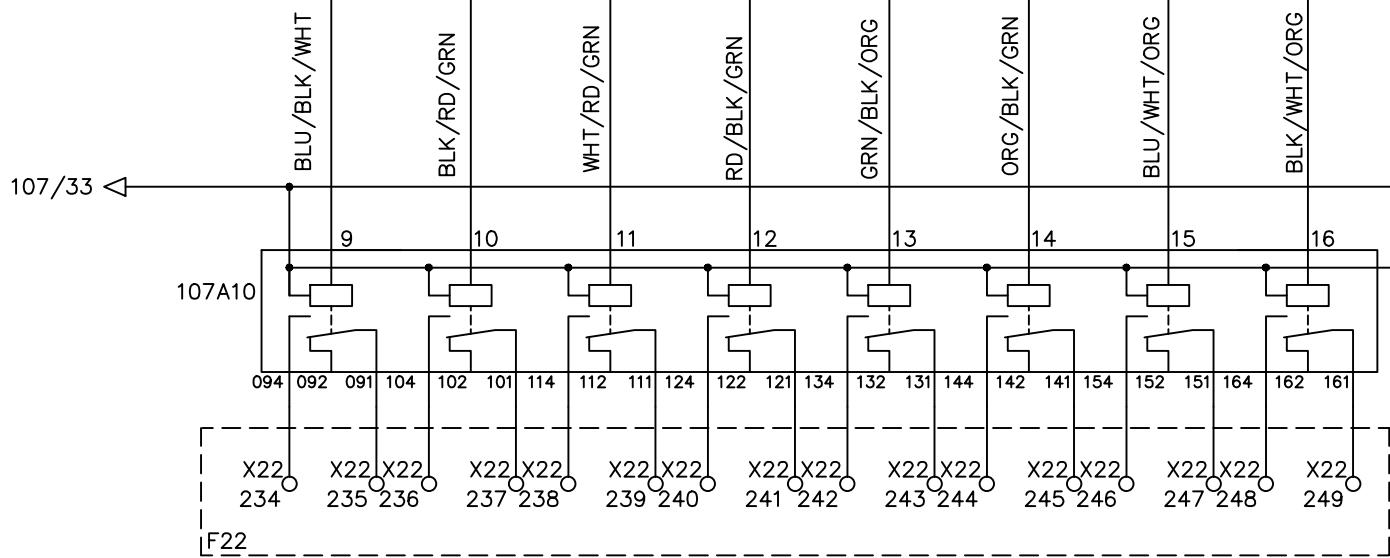
W[511].1 W[518].7 W[518].8 W[518].9 W[518].A W[518].B W[518].C W[518].D

OB2_8 OB2_9 OB2_A OB2_B OB2_C OB2_D OB2_E OB2_F

SLOT 6 / RACK 2

Allen Bradley
1756-OB32

24	25	26	27	28	29	30	31
27	28	29	30	31	32	33	34



File Name : P108 slot 6 Allen Bradley 1756-OB32 rack2-4.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023 E12

Page #
108
Total

DRAWN BY Perrick Hsiao

CHECKED BY JERRY WU

REV. NO REV. DESCRIPTION REV. BY: REV. DATE DRAWN DATE: 03-23-2015 SCALE NONE UNIT MM

1 Add Terminal Number Charlie Z. 06/04/19 DRAWING NO.

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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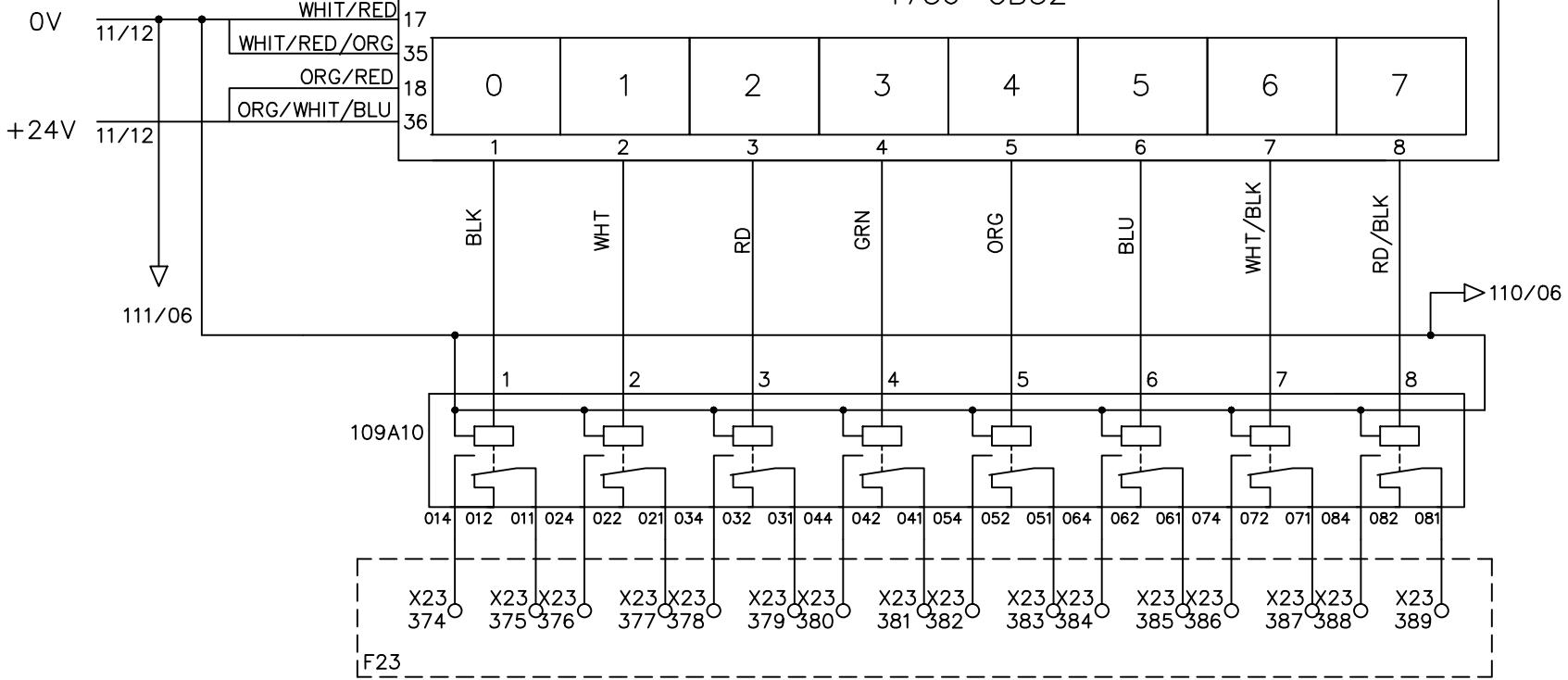
HEATING OF DIVERTER	DIE HEATER Z1	DIE HEATER Z2	DIE HEATER Z3	DIE HEATER Z4	DIE HEATER Z5	DIE HEATER Z6	DIE HEATER Z7
H1250-01	H1260-01	H1260-02	H1260-03	H1260-04	H1260-05	H1260-06	H1260-07

W[513].3 W[513].5 W[513].6 W[513].7 W[513].8 W[513].9 W[513].A W[513].B

OA3_0 OA3_1 OA3_2 OA3_3 OA3_4 OA3_5 OA3_6 OA3_7

SLOT 7 / RACK 2

Allen Bradley
1756-OB32



File Name : P109 slot 7 Allen Bradley 1756-OB32 rack2-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWN BY

Perrick Hsiao

CHECKED BY

JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	MATERIAL	DRAWING DESCRIPTION	KF023 F12	Page #	109
								Total	
1	Add Terminal Number	Charlie Z.	06/04/19			DRAWING NO.			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	03-23-2015	SCALE	NONE	UNIT	MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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MONOLAYER DIVERTER ZONE1	MONOLAYER DIVERTER ZONE2	MONOLAYER DIVERTER ZONE3	FREE	FREE	STATIC MIXER HEATING	STATIC MIXER CONNECTIONS	SAT. 1 HEATING FILTER
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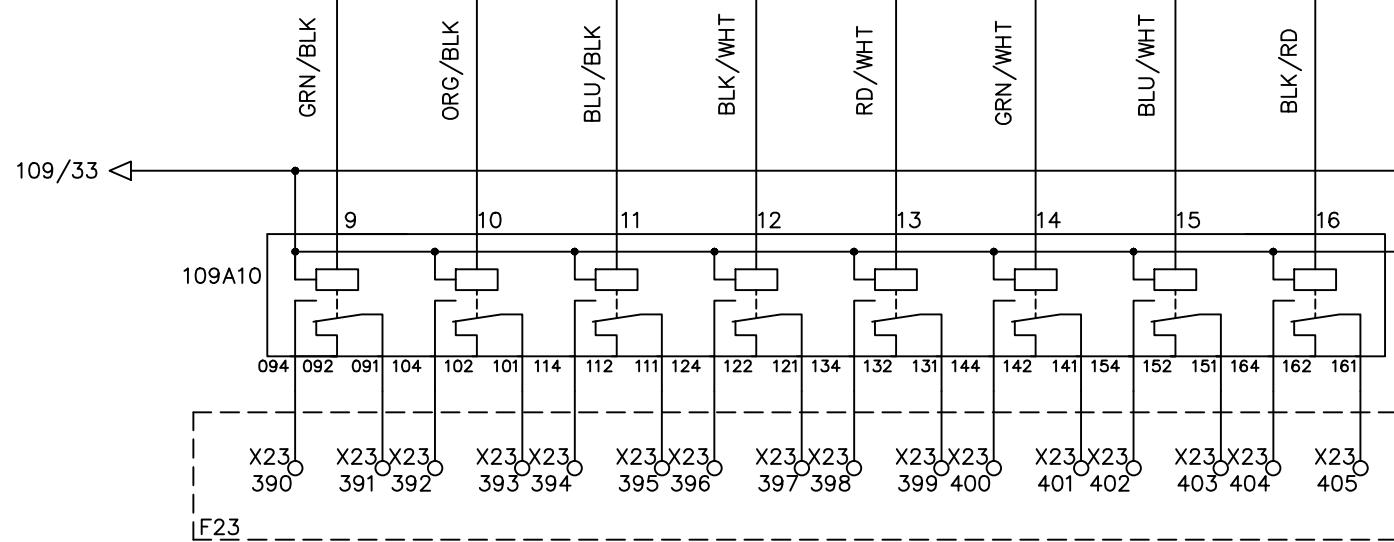
H1251-01 H1251-02 H1232-01

W[213].2 W[513].1 W[510].8

OA3_8 OA3_9 OA3_A OA3_B OA3_C OA3_D OA3_E OA3_F

SLOT 7 / RACK 2
Allen Bradley
1756-OB32

8	9	10	11	12	13	14	15
9	10	11	12	13	14	15	16



File Name : P110 slot 7 Allen Bradley 1756-OB32 rack2-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023 F12

Page #
110
Total

DRAWN BY

Perrick Hsiao

CHECKED BY

JERRY WU

REV. NO

REV. DESCRIPTION

REV. BY:

REV. DATE

DRAWN DATE:

06/05/19

DRAWING NO.

03-23-2015

SCALE

NONE

UNIT

MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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SAT. 2 HEATING FILTER	HYDRAULIC GROUP	HYDRAULIC GROUP	FREE	FREE	FREE	VACUUM VALVE #1	DUMP VALVE #1
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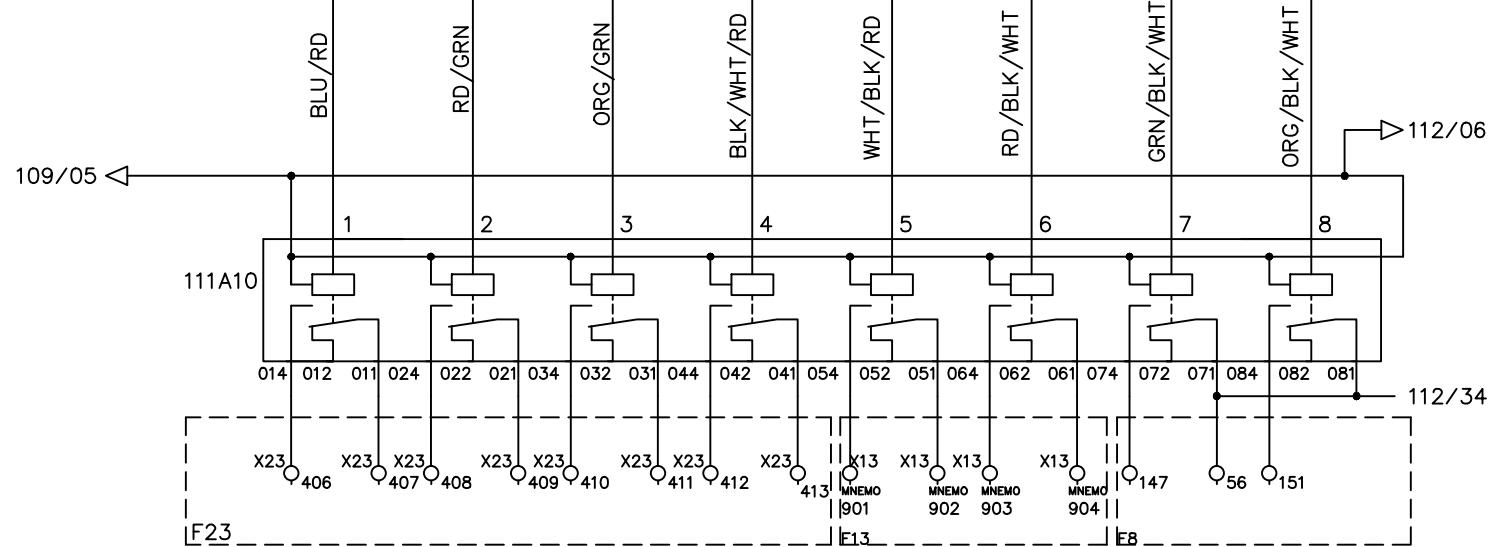
H1232-32 M1232-03 M1232-04

W[511].2 W[517].0 W[517].1

OB3_0 OB3_1 OB3_2 OB3_3 OB3_4 OB3_5 OB3_6 OB3_7

SLOT 7 / RACK 2
Allen Bradley
1756-OB32

16	17	18	19	20	21	22	23
19	20	21	22	23	24	25	26



File Name : P111 slot 7 Allen Bradley 1756-OB32 rack2-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

KF023 F12

Page #
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.		MATERIAL			

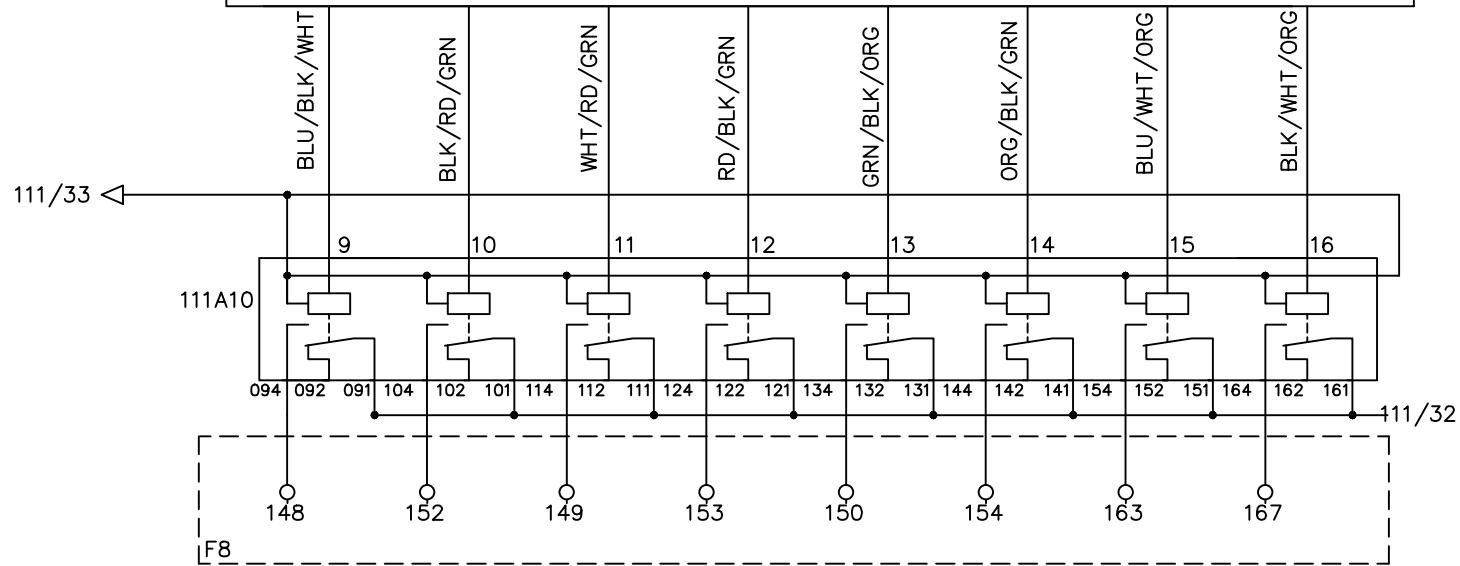
00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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VACUUM VALVE 2	DUMP VALVE 2	VACUUM VALVE 3	DUMP VALVE 3	VACUUM VALVE 4	DUMP VALVE 4	VACUUM VALVE 5	DUMP VALVE 5
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OB3_8 OB3_9 OB3_A OB3_B OB3_C OB3_D OB3_E OB3_F

SLOT 7 / RACK 2
Allen Bradley
1756-OB32

24	25	26	27	28	29	30	31
27	28	29	30	31	32	33	34



File Name : P112 slot 7 Allen Bradley 1756-OB32 rack2-4.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023 F12

Page #
112
Total

DRAWN BY Charlie Zhang

DRAWING NO.

MATERIAL

CHECKED BY JERRY WU

REV. NO REV. DESCRIPTION REV. BY: REV. DATE DRAWN DATE: 05-01-2018 SCALE NONE UNIT MM

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

HEATER ZONE 1 EXT. 1 HEATER ZONE 2 EXT. 1 HEATER ZONE 3 EXT. 1 HEATER ZONE 4 EXT. 1 HEATER ZONE 1 EXT. 2 HEATER ZONE 2 EXT. 2 HEATER ZONE 3 EXT. 2 HEATER ZONE 4 EXT. 2

H1200-01 H1200-02 H1200-03 H1200-04 H1260-06 H1260-07 H1260-08 H1260-09

W[9021].8 W[9071].8 W[9121].8 W[9171].8 W[9221].8 W[9371].8 W[9321].8 W[9371].8

OA4_0 OA4_1 OA4_2 OA4_3 OA4_4 OA4_5 OA4_6 OA4_7

SLOT 8 / RACK 2

Allen Bradley

1756-OB32

The diagram shows a 16-pin DIP switch labeled "11/14". The pins are numbered 0 through 15. The top row of pins (0-7) is connected to a logic board. The bottom row of pins (8-15) is connected to a relay board. The connections are as follows:

- Pin 0: X12 901
- Pin 1: X21 265
- Pin 2: X12 902
- Pin 3: X21 266
- Pin 4: X12 903
- Pin 5: X21 267
- Pin 5: X12 904
- Pin 6: X21 268
- Pin 6: X12 905
- Pin 7: X21 269
- Pin 7: X12 906
- Pin 8: X21 270
- Pin 8: X12 907
- Pin 9: X21 271
- Pin 9: X12 908
- Pin 10: X21 272
- Pin 11: F21
- Pin 12: X12 900
- Pin 13: X21 264
- Pin 14: 0V
- Pin 15: +24V
- Pin 16: 0V

Legend for top row colors:

- WHITE/RED
- WHIT/RED-ORG
- ORG/RED
- ORG/WHIT-BLU

Legend for bottom row colors:

- BLK
- WHT
- RD
- GRN
- ORG
- BLU
- WHT/BLK
- RD/BLK

114/02

File Name : P113 slot 8 Allen Bradley 1756-OB32 rack2-1.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIVI. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

				DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #	113		
						Total			
1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

MELT LINE 1 Z1	MELT LINE 1 Z2	MELT LINE 1 Z3	MELT LINE 1 Z4	FILTER ZONE 1	FILTER ZONE 2	FILTER ZONE 3	ADAPTER
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H1200-12 H1200-13 H1200-14 H1200-15 H1230-02 H1230-03 H1230-04 H1230-05

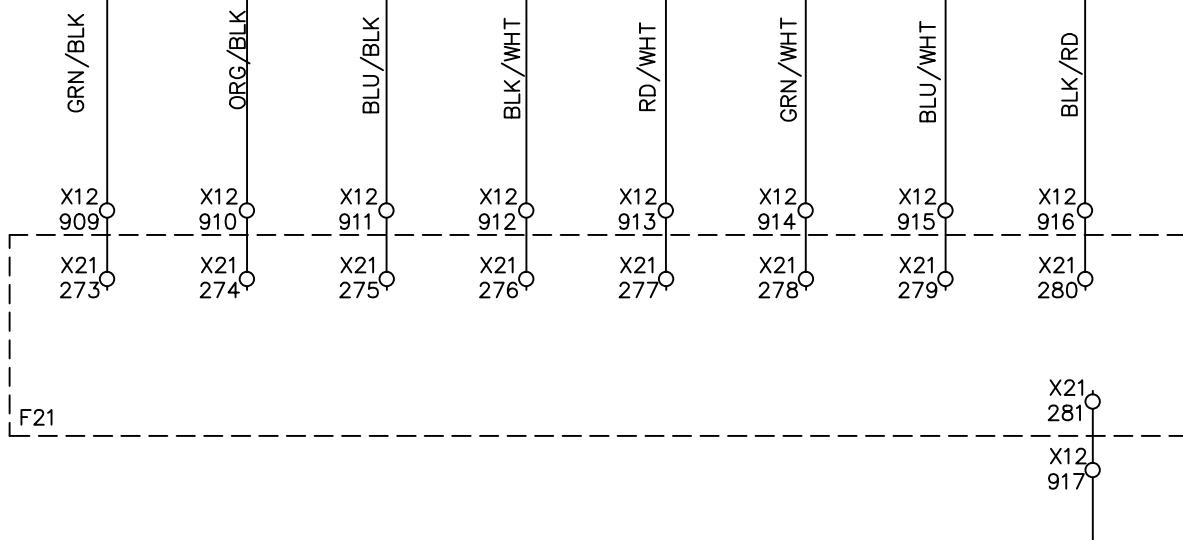
W[6621].8 W[6771].8 W[6721].8 W[6771].8 W[6371].8 W[6421].8 W[6471].8 W[6321].8

OA4_8 OA4_9 OA4_A OA4_B OA4_C OA4_D OA4_E OA4_F

SLOT 8 / RACK 2

Allen Bradley
1756-OB32

8	9	10	11	12	13	14	15
9	10	11	12	13	14	15	16



113/33

115/02

File Name : P114 slot 8 Allen Bradley 1756-OB32 rack2-2.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023 E12
X12 DOOR 6

Page #
114
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.		MATERIAL
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE
					NONE	UNIT
					MM	

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

FILTER ZONE 1	FILTER ZONE 2	FILTER ZONE 3	ADAPTER	FREE	FREE	FREE	FREE
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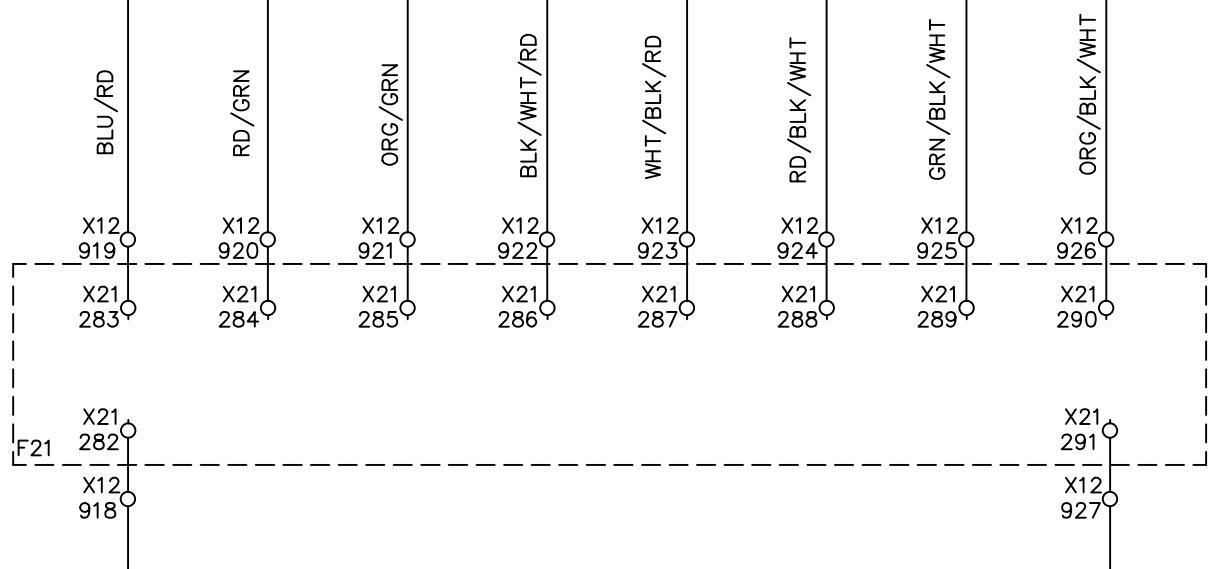
H1231-02 H1231-03 H1231-04 H1231-05

W[6871].8 W[6921].8 W[6971].8 W[6821].8

OB4_0 OB4_1 OB4_2 OB4_3 OB4_4 OB4_5 OB4_6 OB4_7

SLOT 8 / RACK 2
Allen Bradley
1756-OB32

16	17	18	19	20	21	22	23
19	20	21	22	23	24	25	26



114/34

116/02

File Name : P115 slot 8 Allen Bradley 1756-OB32 rack2-3.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING DESCRIPTION KF023 E12
X12 DOOR 6

Page # 115
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.		MATERIAL
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE
					NONE	UNIT
					MM	

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

SAT. EXT. 2 Z1	SAT. EXT. 2 Z2	SAT. EXT. 2 Z3	SAT. EXT. 2 Z4	SAT. EXT. 2 Z5	SAT. EXT. 2 Z6	SAT. EXT. 2 Z7	ADAPTER SAT. EXT. 2
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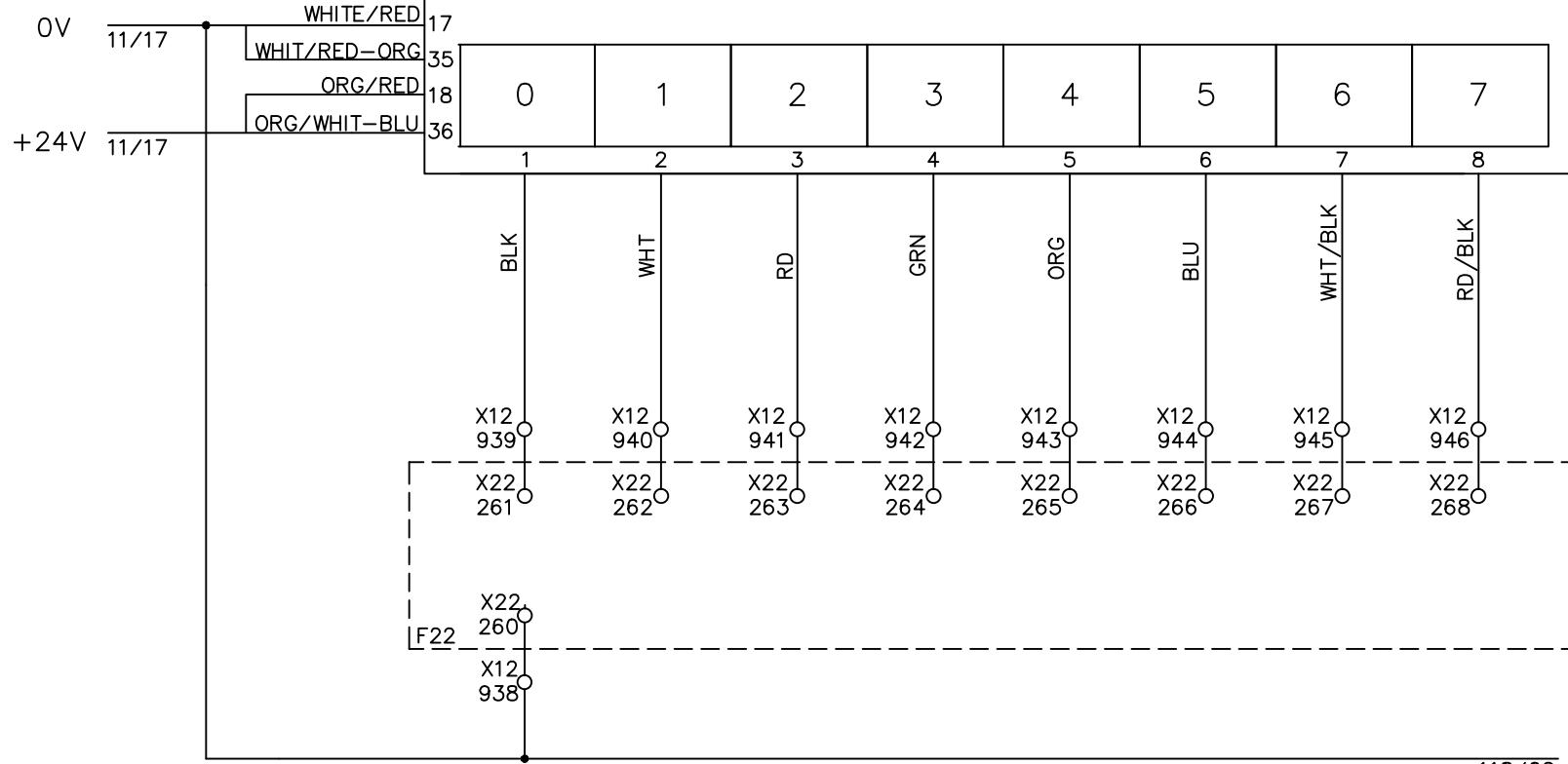
H1210-15 H1210-16 H1210-17 H1210-18 H1210-19 H1210-20 H1210-21 H1210-30

W[8371].8 W[8421].8 W[8471].8 W[8521].8 W[8571].8 W[8621].8 W[8671].8 W[6171].8

OA5_0 OA5_1 OA5_2 OA5_3 OA5_4 OA5_5 OA5_6 OA5_7

SLOT 9 / RACK 2

Allen Bradley
1756-OB32



118/02

File Name : P117 slot 9 Allen Bradley 1756-OB32 rack2-1.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	Page #	
					KF023 E12 X12 DOOR 6	Total
1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.		MATERIAL
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE NONE UNIT MM

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FREE

FREE

FREE

FREE

HEATING
OF
DIVERTERDIE
HEATER
Z1DIE
HEATER
Z2DIE
HEATER
Z3

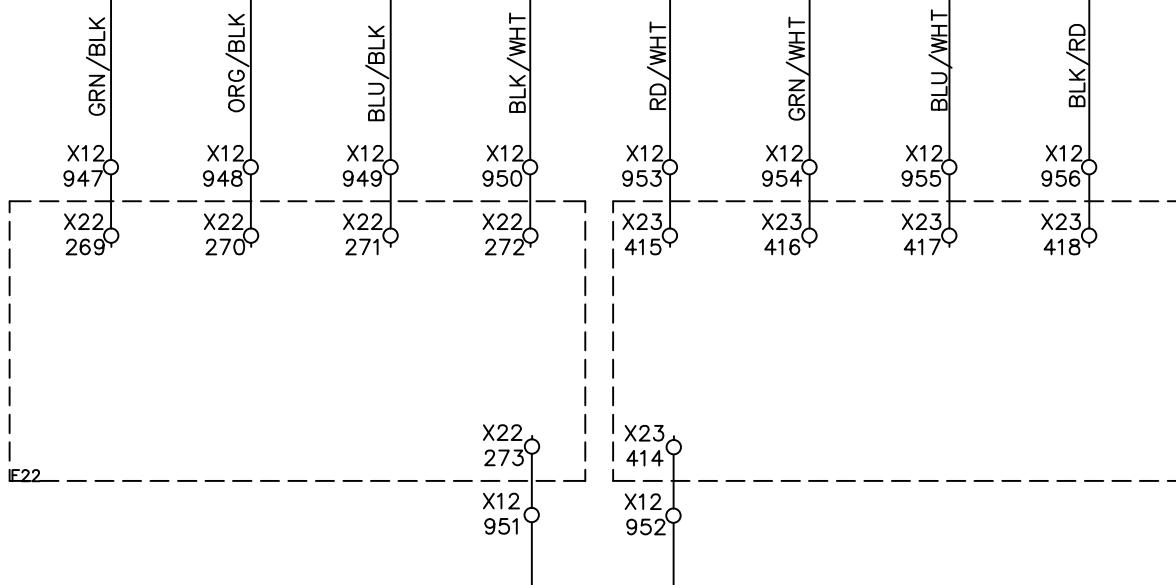
H1250-01 H1260-01 H1260-02 H1260-03

W[7221].C W[7271].8 W[7321].8 W[7371].8

OA5_8 OA5_9 OA5_A OA5_B OA5_C OA5_D OA5_E OA5_F

SLOT 9 / RACK 2
 Allen Bradley
 1756-OB32

8	9	10	11	12	13	14	15
9	10	11	12	13	14	15	16



117/33

119/02

File Name : P118 slot 9 Allen Bradley 1756-OB32 rack2-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023 E12
X12 DOOR 6Page #
118
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.		MATERIAL
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE
					NONE	UNIT
					MM	

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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DIE HEATER Z4	DIE HEATER Z5	DIE HEATER Z6	DIE HEATER Z7	STATIC MIXER HEATING	STATIC MIXER CONNECTIONS	SAT. 1 HEATING FILTER	SAT. 2 HEATING FILTER
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H1260-04	H1260-05	H1260-06	H1260-07	H1251-01	H1251-02	H1232-01	H1232-02
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W[7421].8	W[7471].8	W[7521].8	W[7571].8	W[7121].8	W[7171].8	W[6071].8	W[6220].8
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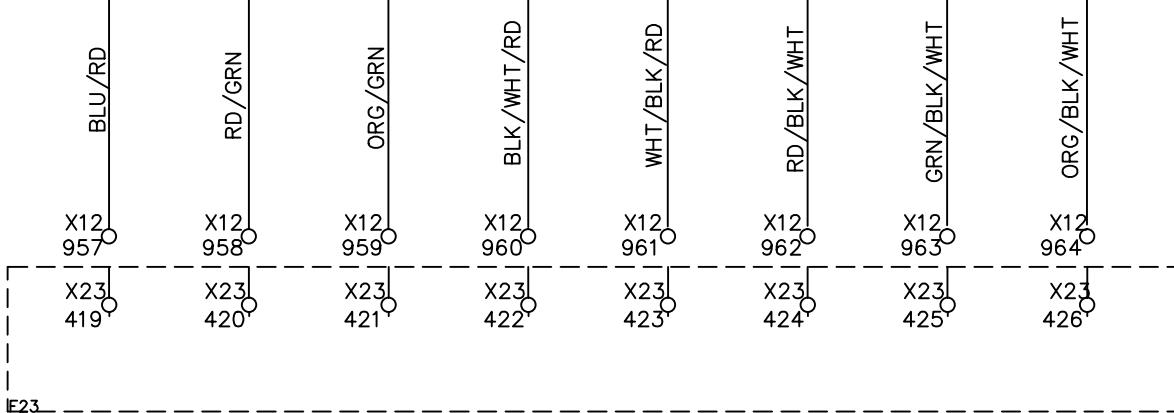
OB5_0	OB5_1	OB5_2	OB5_3	OB5_4	OB5_5	OB5_6	OB5_7
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SLOT 9 / RACK 2

Allen Bradley

1756-OB32

16	17	18	19	20	21	22	23
19	20	21	22	23	24	25	26



118/34

120/02

File Name : P119 slot 9 Allen Bradley 1756-OB32 rack2-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

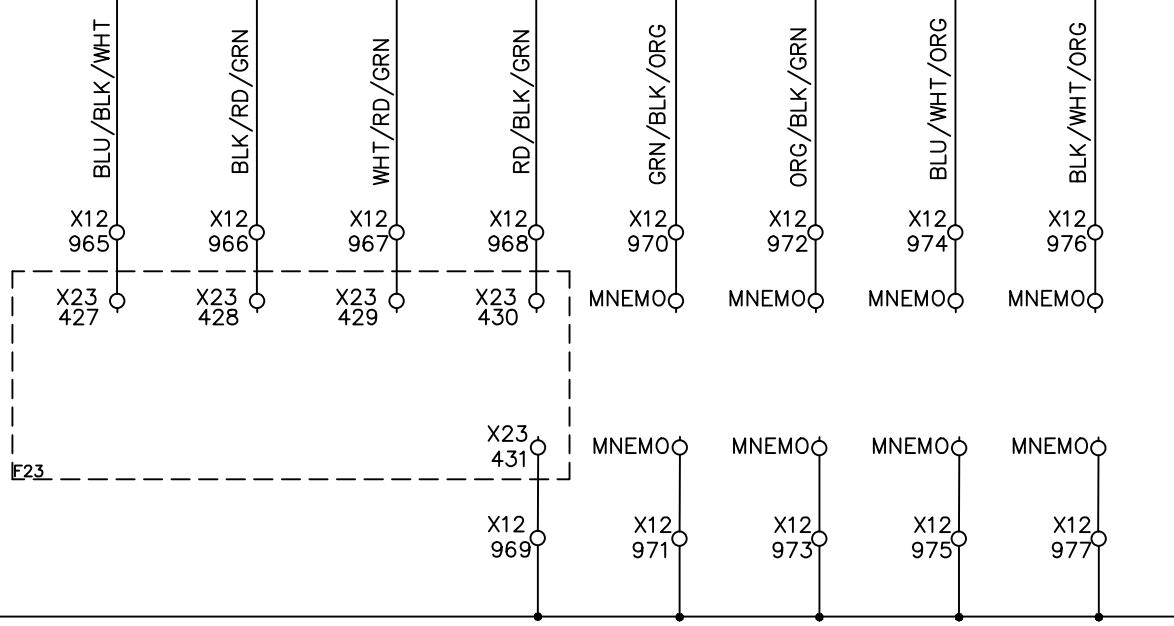
				DRAWING DESCRIPTION	KF023 E12 X12 DOOR 6	Page #	119
						Total	
DRAWN BY	Rufus Huang					MATERIAL	
CHECKED BY	JERRY WU	REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018

	MAIN EXTR STATIC MIXER	MONOLAYER DIVERTER ZONE1	MONOLAYER DIVERTER ZONE2	MONOLAYER DIVERTER ZONE3	FREE		FREE	FREE	
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OB5_8 OB5_9 OB5_A OB5_B OB5_C OB5_D OB5_E OB5_F

SLOT 9 / RACK 2
Allen Bradley
1756-OB32

24	25	26	27	28	29	30	31
27	28	29	30	31	32	33	34



119/34

File Name : P120 slot 9 Allen Bradley 1756-OB32 rack2-4.dwg

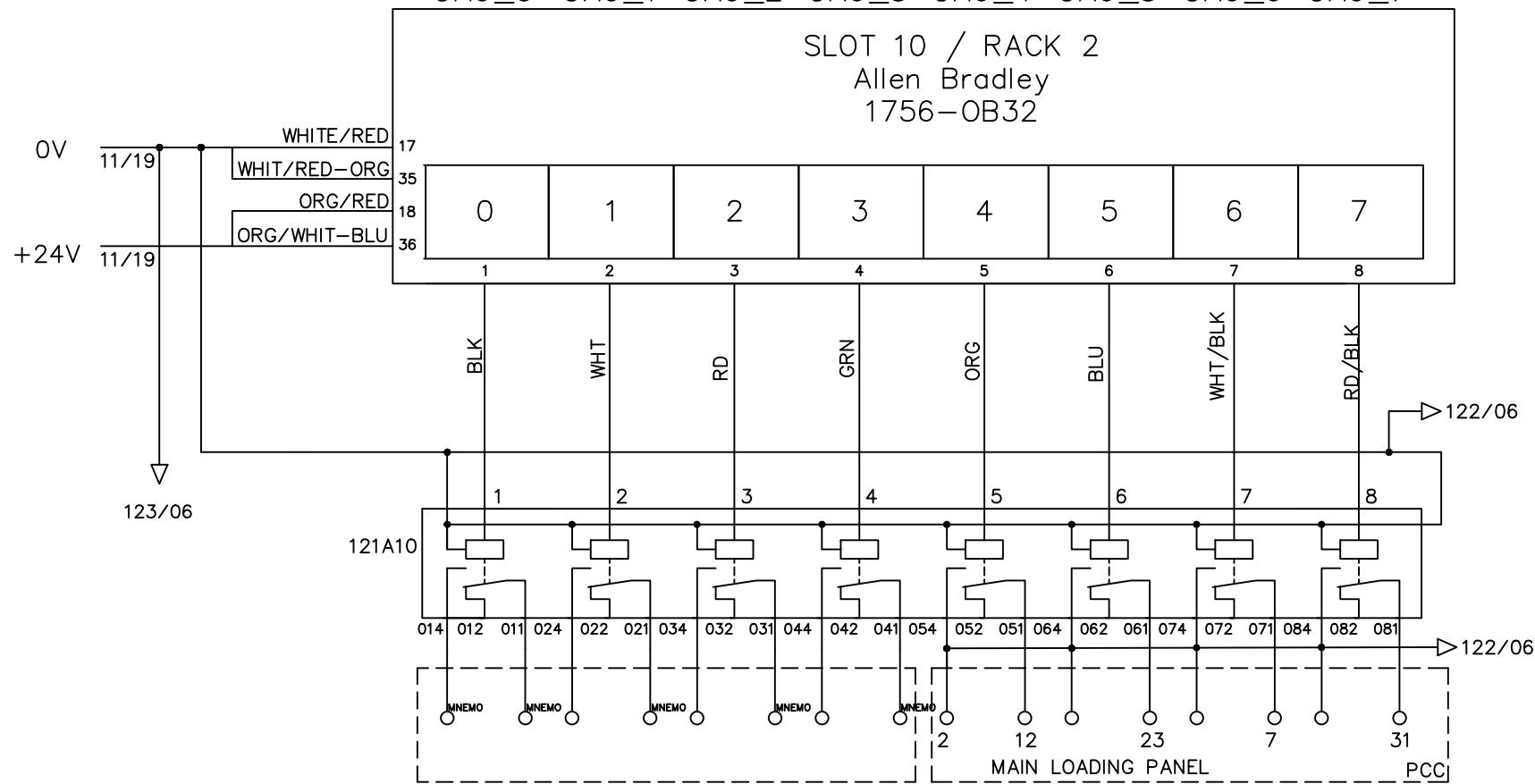
00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

FREE FREE FREE FREE HOMOPOLYMER RECLAIM COPOLYMER SILO MATERIAL SILO DRYER HI

C1103-01 C1103-02 C1122-01 C1122-02 LSH1104-02 LSH1104-04 LSL1123-01 LSL1123-02

HOMO RECLAIM SAT1 SAT2 DRYEA DRYEA DRYEA DRYEA

OA6_0 OA6_1 OA6_2 OA6_3 OA6_4 OA6_5 OA6_6 OA6_7



File Name : P121 slot 10 Allen Bradley 1756-OB32 rack2-1.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIVI. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

				DRAWING DESCRIPTION	KF023 F12	Page #	121		
						Total			
1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.		MATERIAL			
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

SAT EXT. 1	SAT EXT. 1	COPOLYMER SILO	COPOLYMER2 SILO DRYER HI	SAT EXT. 2	SAT EXT. 2	HOMOPOLY MER SILO	RECLAIM MATERIAL
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LSL1124-01 LSL1124-02 LSL1123-03 LSH1123-04 LSL1124-03 LSL1124-04 LSL1104-01 LSL1104-03

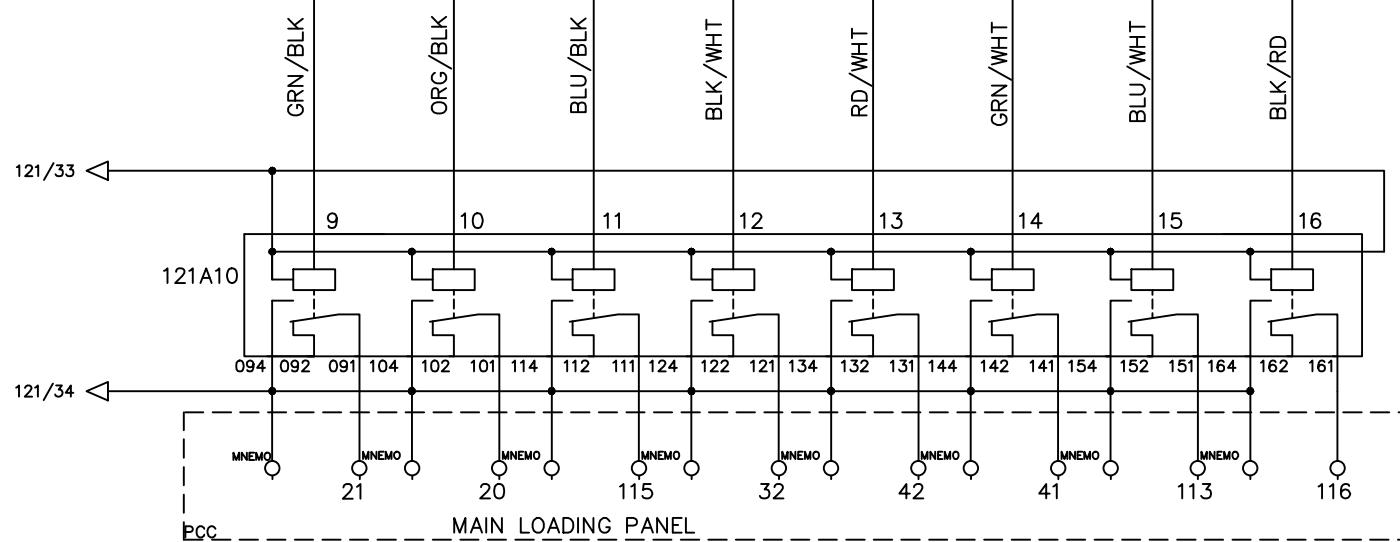
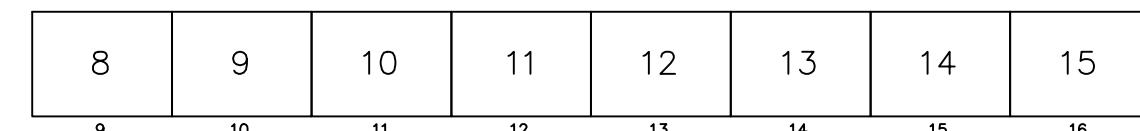
HOPPER HOPPER DRYER DRYER HOPPER HOPPER DRYER DRYER

W[4943].E W[4943].D NOT I94.E W[4943].2 W[4943].4

OA6_8 OA6_9 OA6_A OA6_B OA6_C OA6_D OA6_E OA6_F

SLOT 10 / RACK 2

Allen Bradley
1756-OB32



File Name : P122 slot 10 Allen Bradley 1756-OB32 rack2-2.dwg

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023 F12

Page #
122
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.		MATERIAL
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE
					NONE	UNIT
					MM	

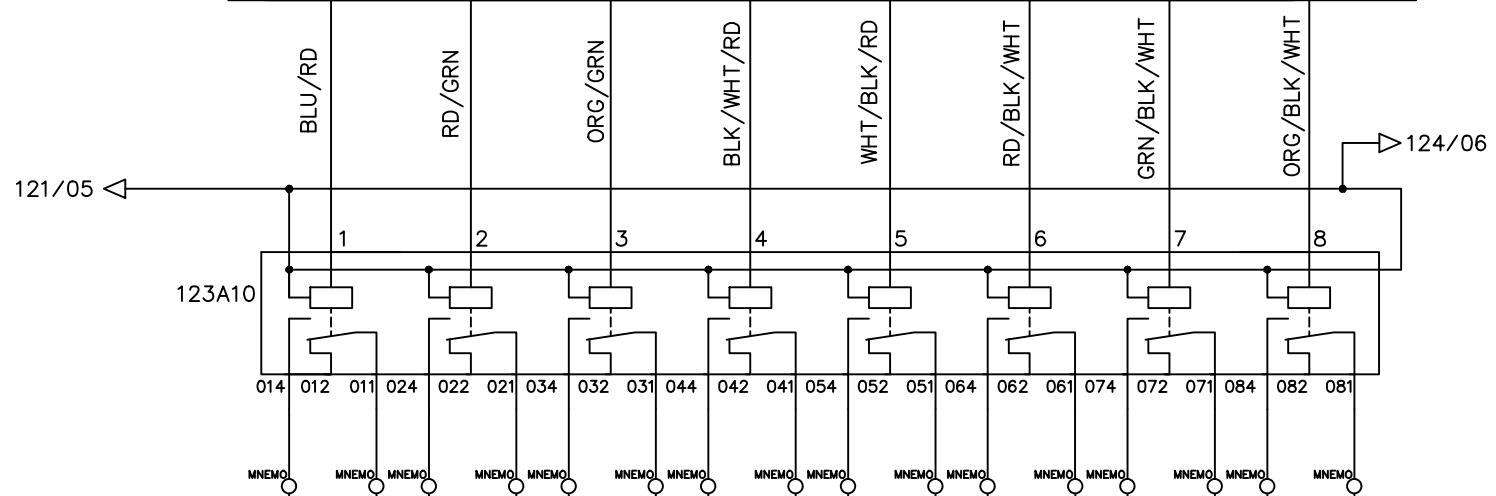
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FREE							
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OB6_0 OB6_1 OB6_2 OB6_3 OB6_4 OB6_5 OB6_6 OB6_7

SLOT 10 / RACK 2
Allen Bradley
1756-OB32

16	17	18	19	20	21	22	23
19	20	21	22	23	24	25	26



File Name : P123 slot 10 Allen Bradley 1756-OB32 rack2-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING DESCRIPTION
KF023
F12

Page #
123
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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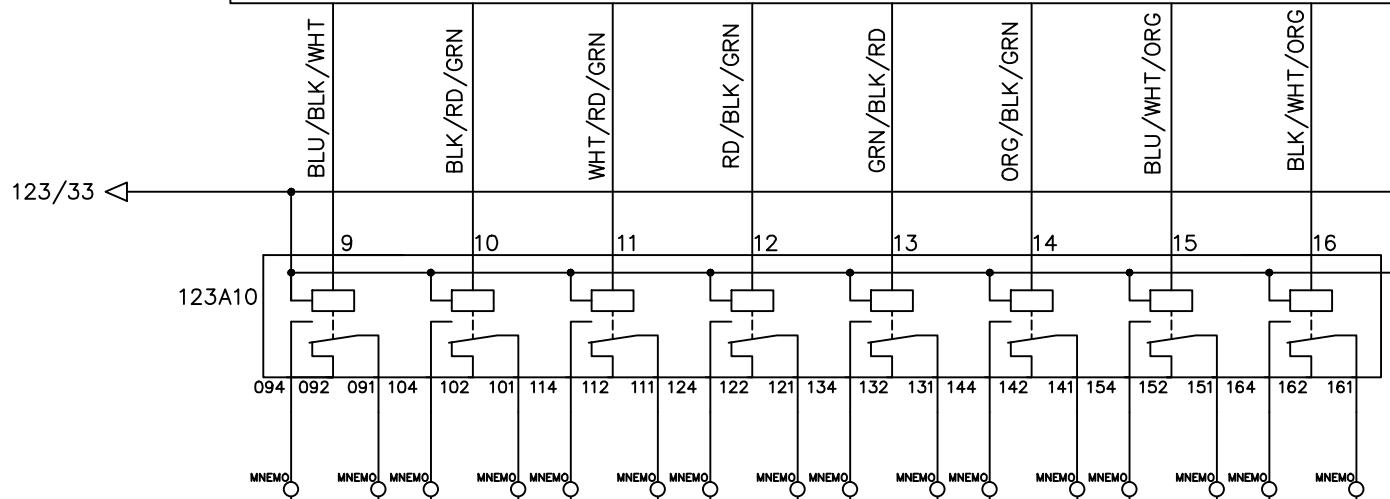
FREE							
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OB6_8 OB6_9 OB6_A OB6_B OB6_C OB6_D OB6_E OB6_F

SLOT 10 / RACK 2

Allen Bradley
1756-OB32

24	25	26	27	28	29	30	31
27	28	29	30	31	32	33	34



File Name : P124 slot 10 Allen Bradley 1756-OB32 rack2-4.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING DESCRIPTION
KF023
F12

Page #
124
Total

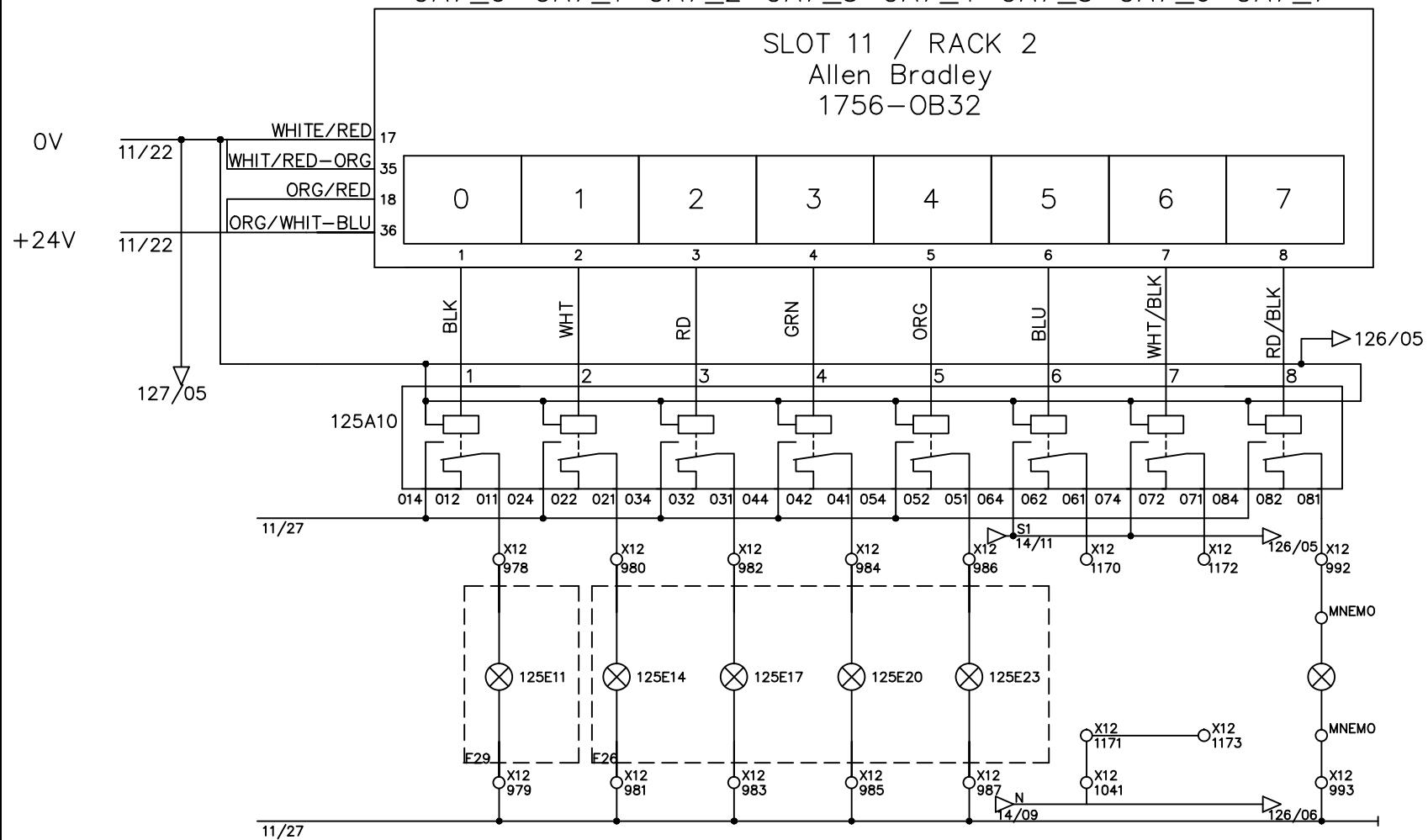
DRAWN BY Rufus Huang

CHECKED BY JERRY WU

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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W[4943].3 W[4943].5 W[4943].1 W[4943].E W[4929].8

OA7_0 OA7_1 OA7_2 OA7_3 OA7_4 OA7_5 OA7_6 OA7_7



File Name : P125 slot 11 Allen Bradley 1756-OB32 rack2-1.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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REMOTE START	REMOTE STOP	REMOTE START	REMOTE STOP	REMOTE START	REMOTE STOP	REMOTE START	REMOTE STOP
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C1103-01	C1103-01	C1103-02	C1103-02	C1122-01	C1122-01	C1122-02	C1122-02
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W[515].0	W[515].1	W[515].9	W[515].A
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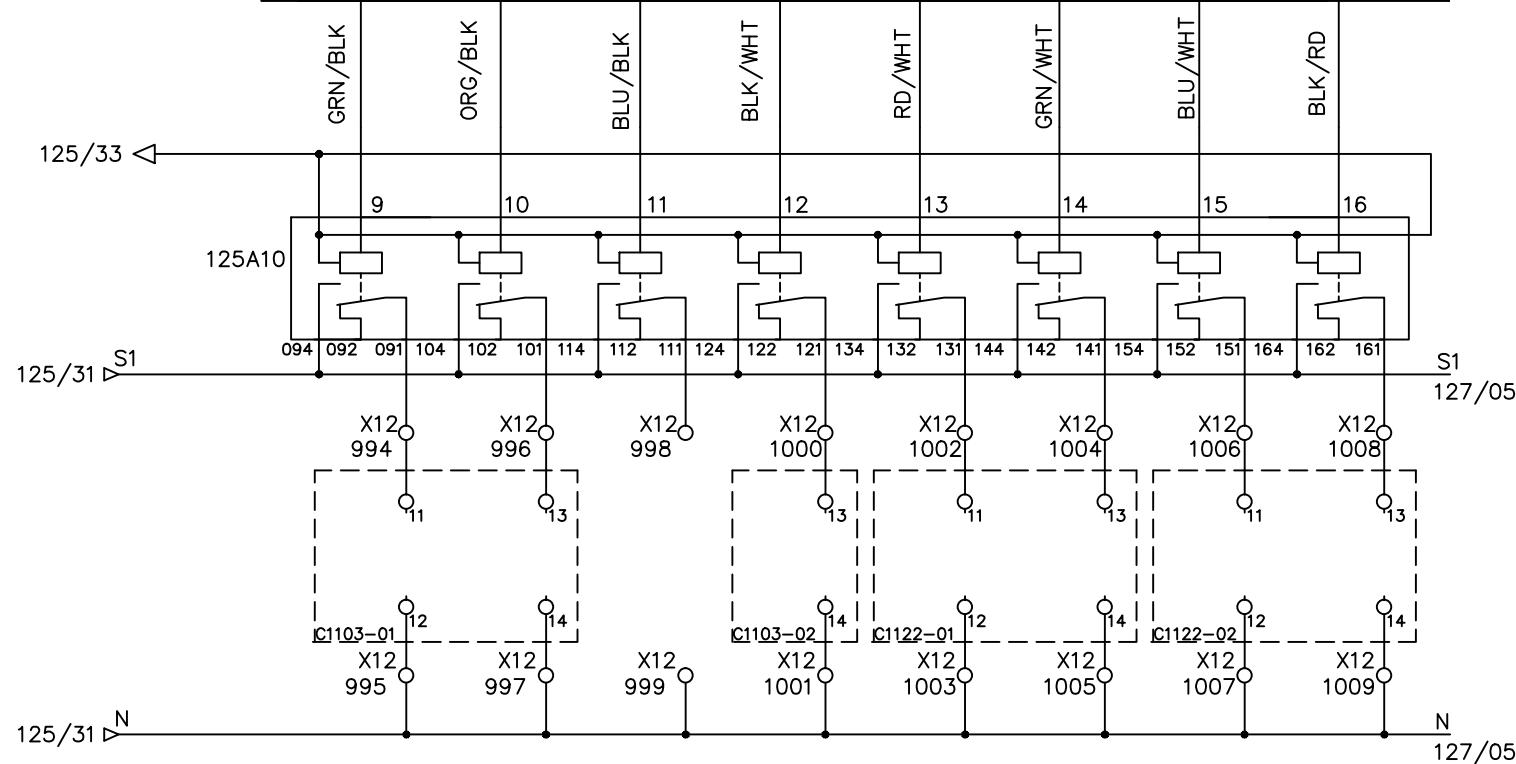
OA7_8	OA7_9	OA7_A	OA7_B	OA7_C	OA7_D	OA7_E	OA7_F
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SLOT 11 / RACK 2

Allen Bradley
1756-OB32

8	9	10	11	12	13	14	15
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9	10	11	12	13	14	15	16
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File Name : P126 slot 11 Allen Bradley 1756-OB32 rack2-2.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING
DESCRIPTION
KF023 E12
X12 DOOR 6

Page #
126
Total

DRAWN BY Rufus Huang

CHECKED BY JERRY WU

1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.		MATERIAL
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE
					NONE	UNIT
					MM	

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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FEEDING VALVE	CONAIR RIGHT BAG	SECONDARY MELTLINE 1 PART	SECONDARY MELTLINE 2 PART	MELTLINE SAT. EXT. 1	MELTLINE SAT. EXT. 2	COOL.EXT.1 FEEDING ZONE	COOLING EXT. 1 Z1
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SV1114-01

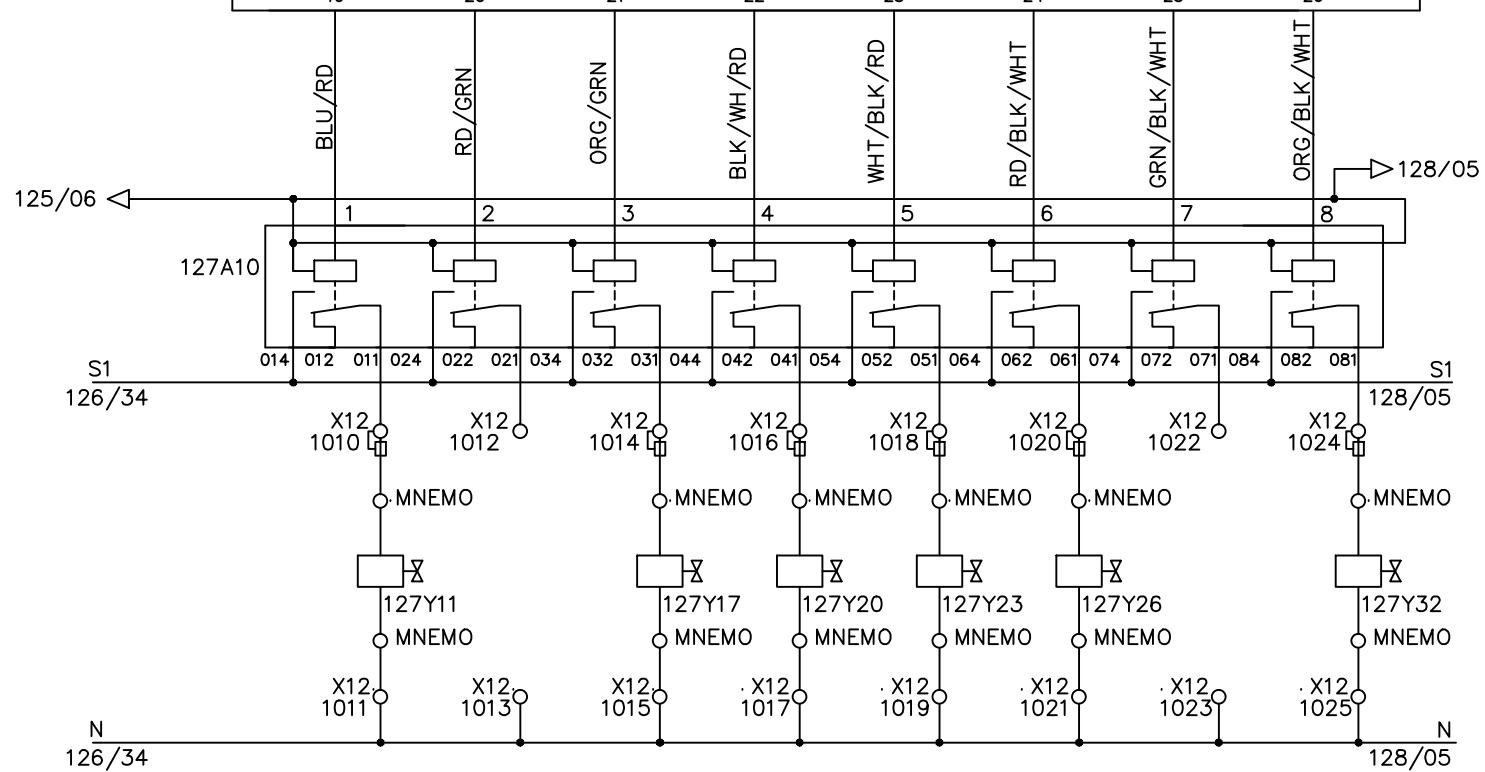
SV1240-03 SV1240-04 SV1245-01 SV1245-02 SV1200-00 SV1200-01

W[4929].7 W[508].E

OB7_0 OB7_1 OB7_2 OB7_3 OB7_4 OB7_5 OB7_6 OB7_7

SLOT 11 / RACK 2
Allen Bradley
1756-OB32

16	17	18	19	20	21	22	23
19	20	21	22	23	24	25	26



File Name : P127 slot 11 Allen Bradley 1756-OB32 rack2-3.dwg

00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 32 P.L.C. DIGITAL OUTPUT

DRAWING DESCRIPTION	KF023 F12	Page #	127
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Total

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.					
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REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.					
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REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	05-01-2018	SCALE	NONE	UNIT	MM
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1	Add Terminal Number	Charlie Z.	06/05/19	DRAWING NO.					
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00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
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COOLING EXT. 1 Z2	COOLING EXT. 1 Z3	COOLING EXT. 1 Z4	CONN AIR LEFT BAG	COOLING EXT. 2 Z1	COOLING EXT. 2 Z2	COOLING EXT. 2 Z3	COOLING EXT. 2 Z4
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SV1200-02 SV1200-03 SV1200-04

SV1200-06 SV1200-07 SV1200-08 SV1200-09

W[508].F W[509].0 W[509].1

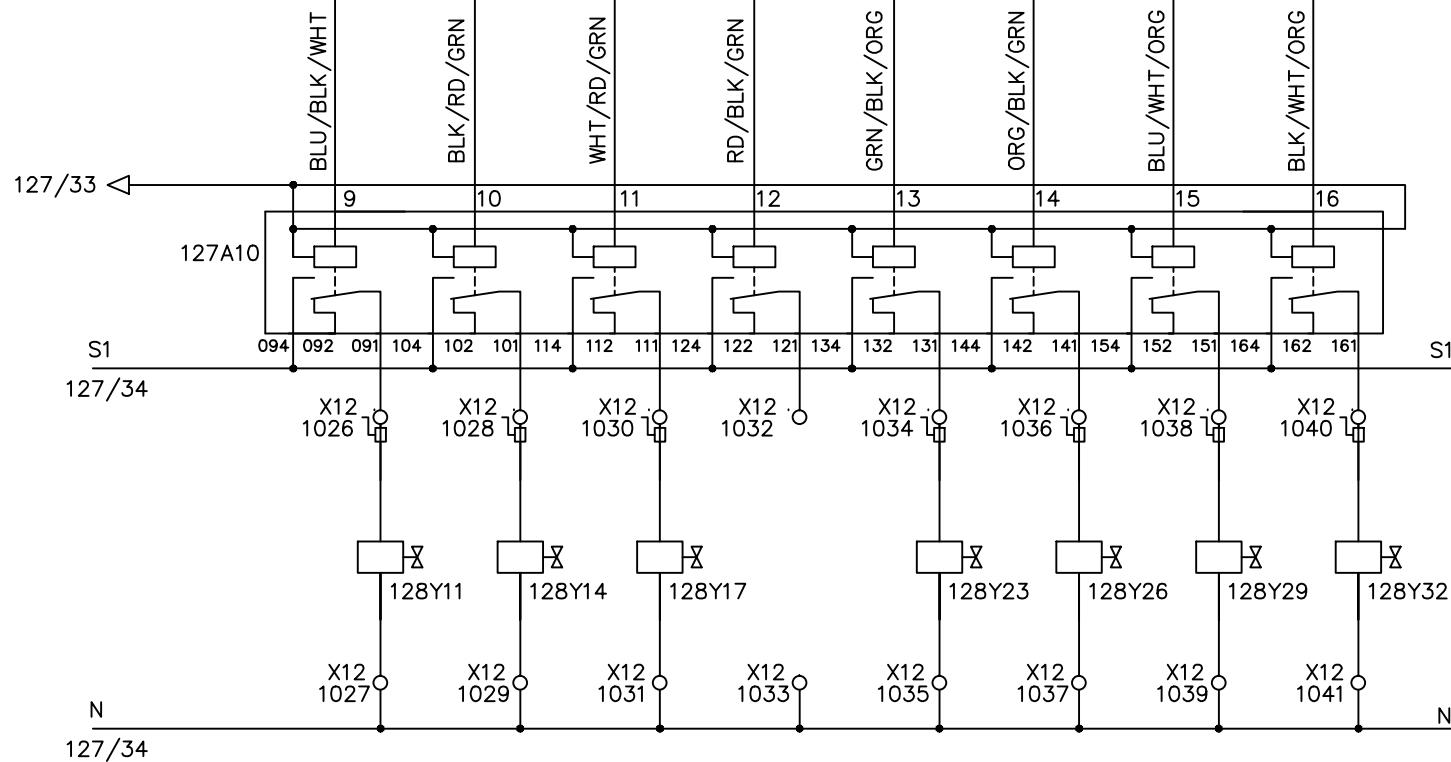
W[509].2 W[509].3 W[509].4

OB7_8 OB7_9 OB7_A OB7_B OB7_C OB7_D OB7_E OB7_F

SLOT 11 / RACK 2

Allen Bradley
1756-OB32

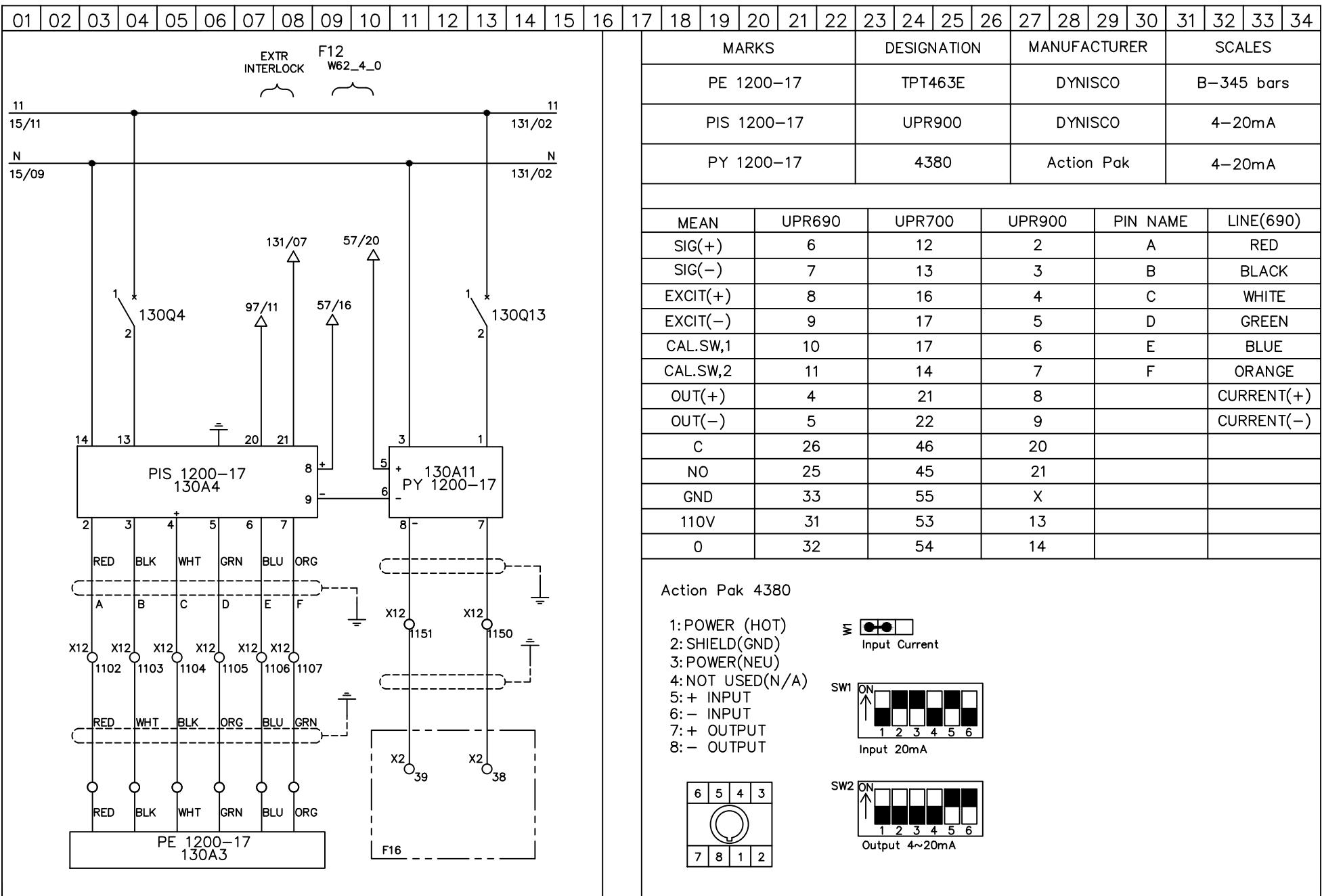
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27	28	29	30	31	32	33	34



File Name : P128 slot 11 Allen Bradley 1756-OB32 rack2-4.dwg

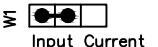
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DRAWN BY	Rufus Huang	Line4 32 P.L.C. DIGITAL OUTPUT			DRAWING DESCRIPTION	KF023 F12 X12 DOOR 6	Page #	128
								Total
CHECKED BY	JERRY WU	1	Add Terminal Number	Charlie Z.	06/06/19	DRAWING NO.		MATERIAL
		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:		SCALE NONE UNIT MM

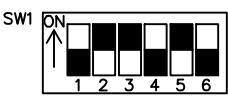


Action Pak 4380

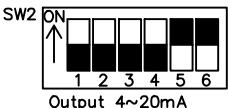
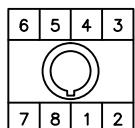
- 1: POWER (HOT)
- 2: SHIELD(GND)
- 3: POWER(NEU)
- 4: NOT USED(N/A)
- 5: + INPUT
- 6: - INPUT
- 7: + OUTPUT
- 8: - OUTPUT



Input Current



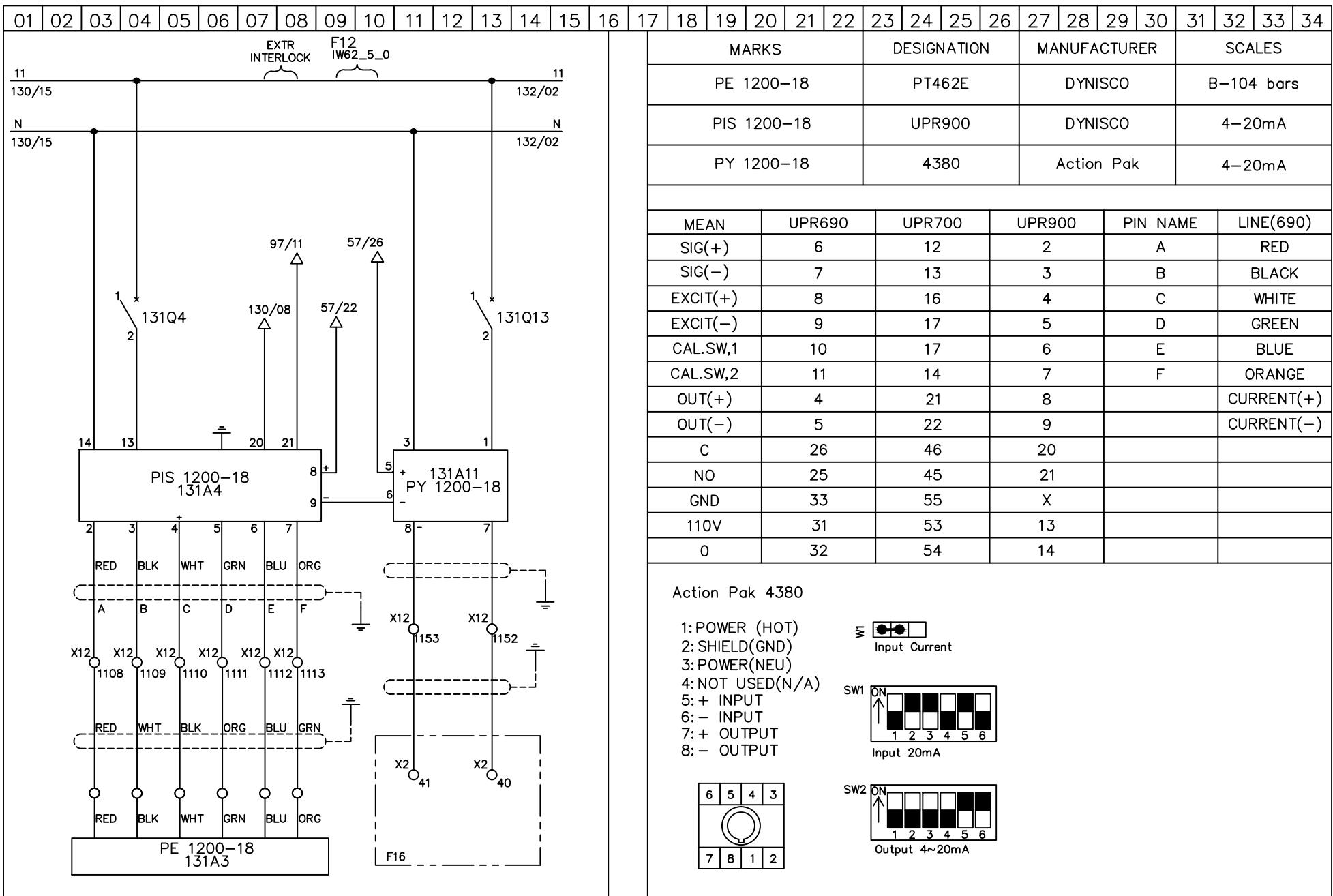
Input 20mA



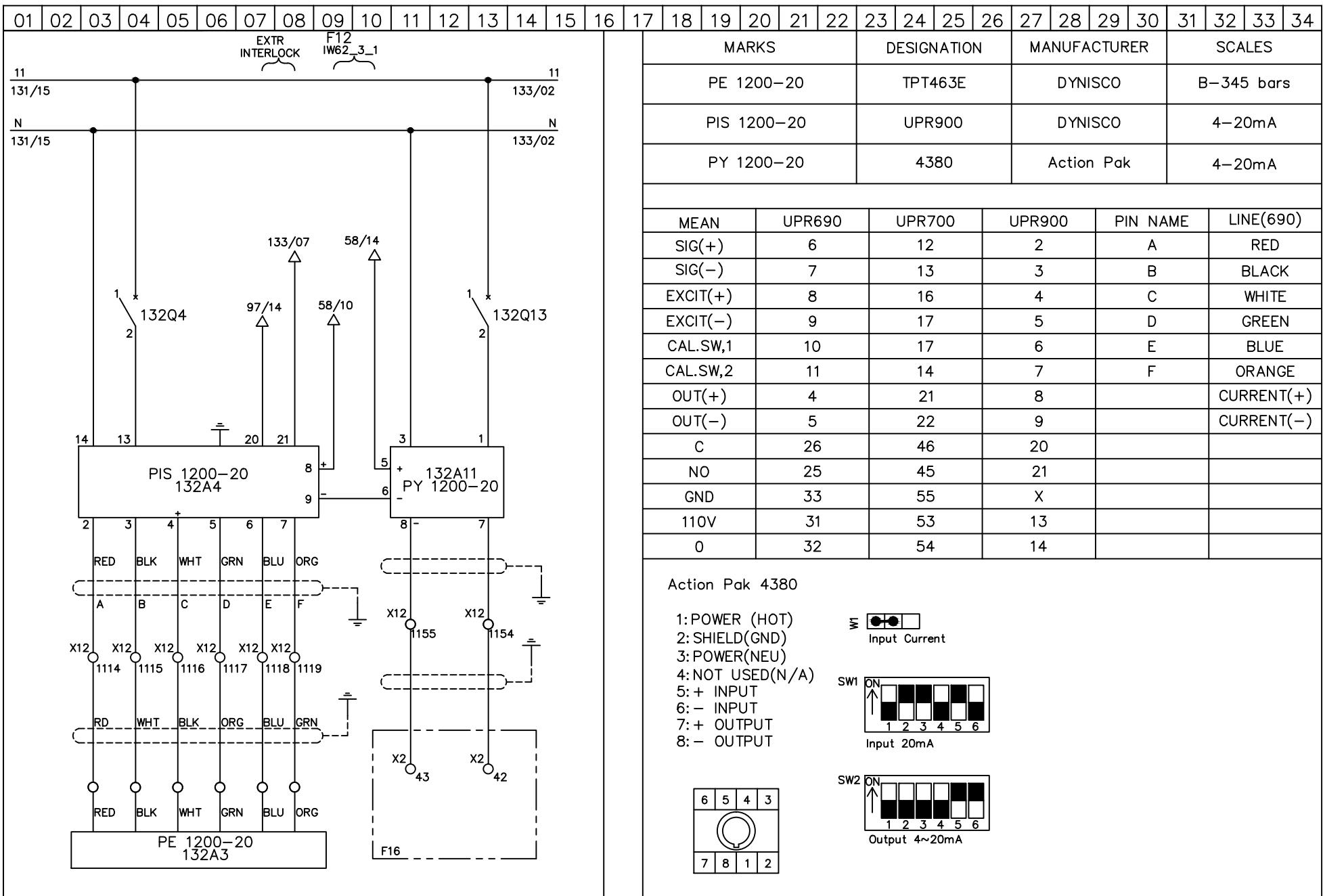
Output 4~20mA

01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.														DRAWING DESCRIPTION		KF012		Page #		130												
DRAWN BY	Charlie Zhang																						Total										
CHECKED BY	VINCENT HUANG																						MATERIAL										
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	10/15/2018	SCALE	NONE	UNIT	MM																								

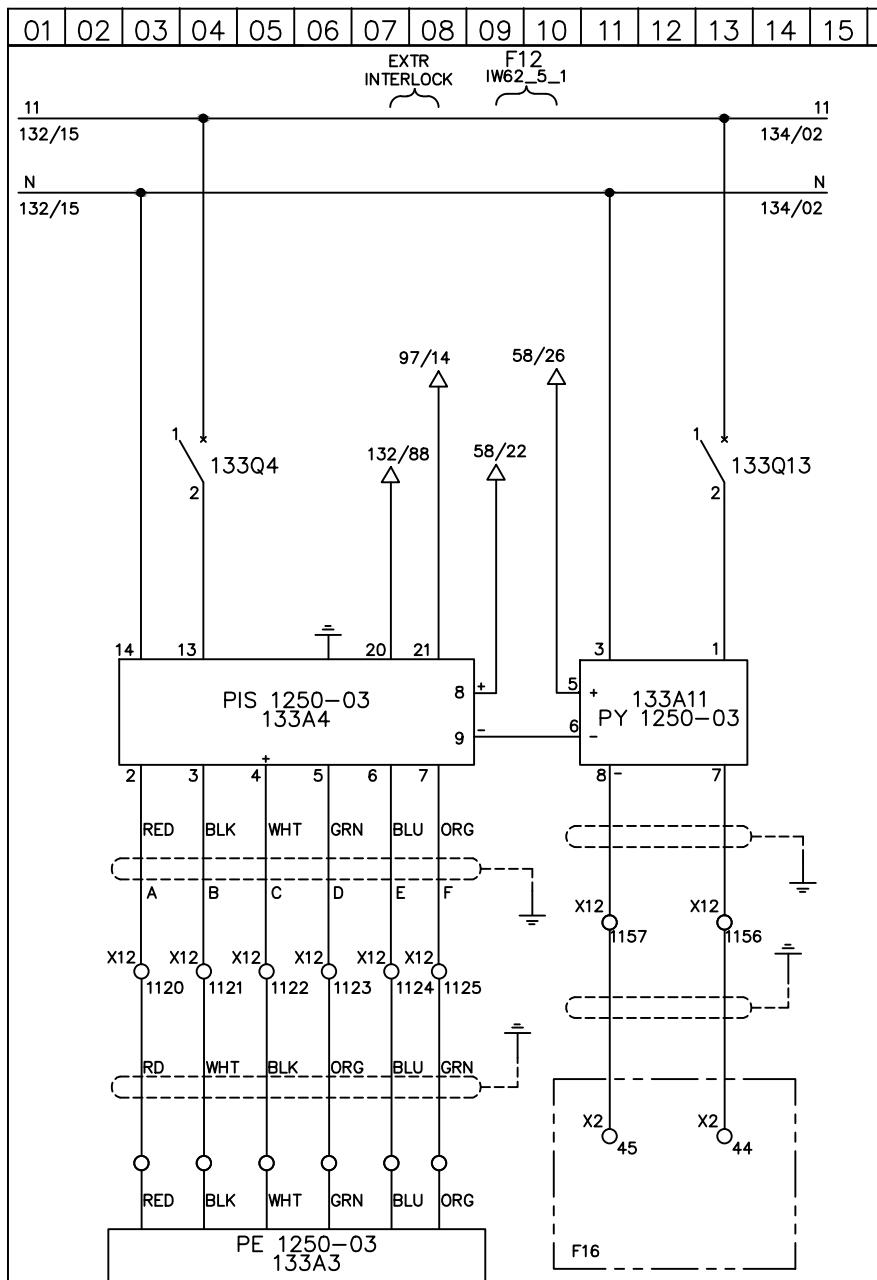
Line4 MELT PRESSURE AFTER EXT.1
PE 1200-17 (P511, 0-5000PSI)



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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.				Line4 MELT PRESSURE BEFORE EXT.2												DRAWING DESCRIPTION		KF023		Page #		131										
DRAWN BY	Charlie Zhang				PE 1200-18 (P512, 0-1500PSI)																Total												
CHECKED BY	VINCENT HUANG																DRAWING NO.				MATERIAL												
					REV. NO		REV. DESCRIPTION		REV. BY:		REV. DATE		DRAWN DATE:		10/15/2018		SCALE	NONE	UNIT	MM													



01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.														Line4 MELT PRESSURE AFTER EXT.2 PE 1200-20 (P514, 0-5000PSI)																		
DRAWN BY	Charlie Zhang														DRAWING DESCRIPTION																		
CHECKED BY	VINCENT HUANG														DRAWING NO.																		
															Page #																		
															Total																		
REV. NO	REV. DESCRIPTION														REV. BY:	REV. DATE																	
														DRAWN DATE: 10/15/2018																			
														SCALE		NONE		UNIT		MM													



Action Pak 4380

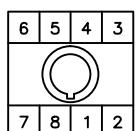
- 1: POWER (HOT)
 - 2: SHIELD(GND)
 - 3: POWER(NEU)
 - 4: NOT USED(N/A)
 - 5: + INPUT
 - 6: - INPUT
 - 7: + OUTPUT
 - 8: - OUTPUT



t Current



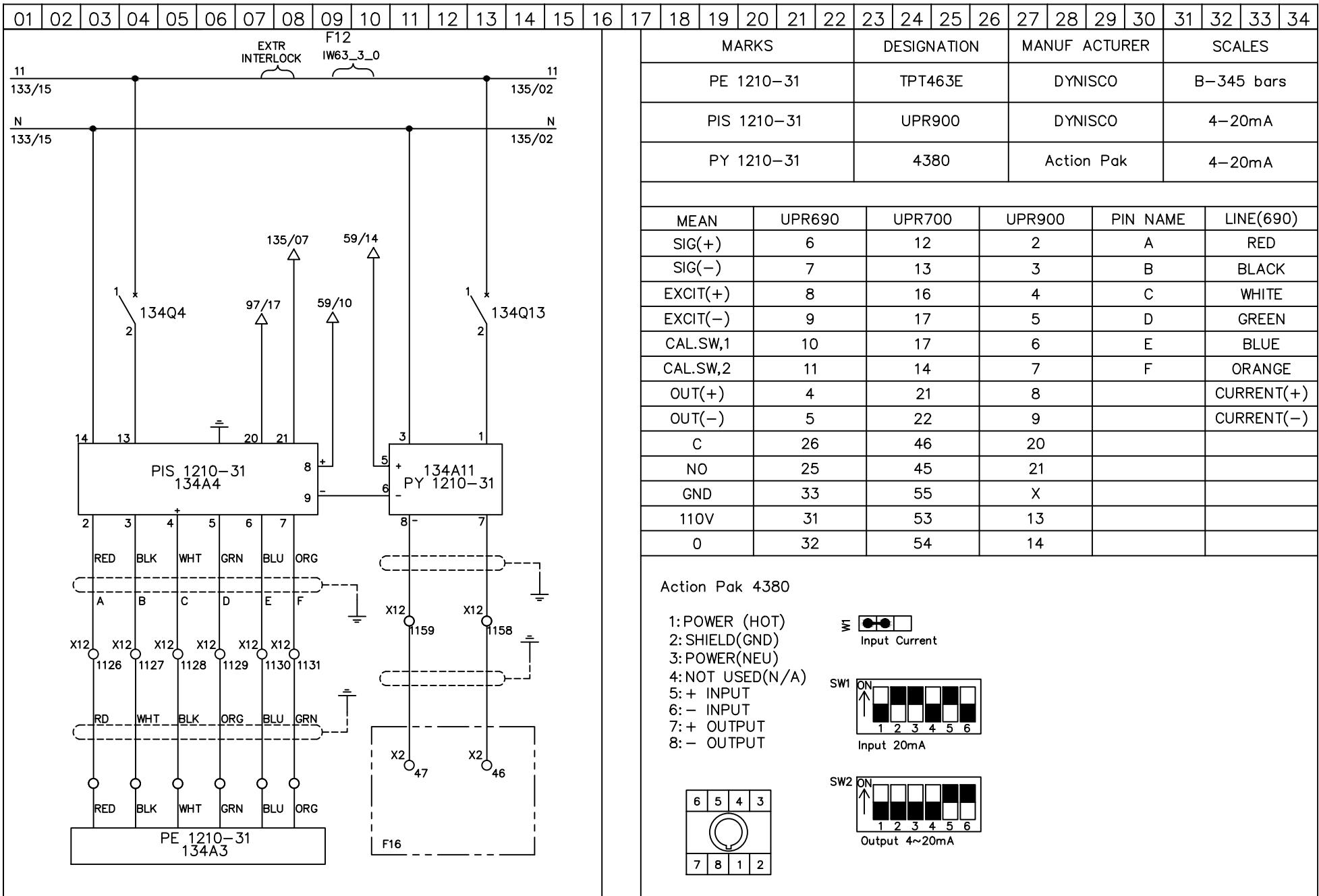
1 / 2 - 3



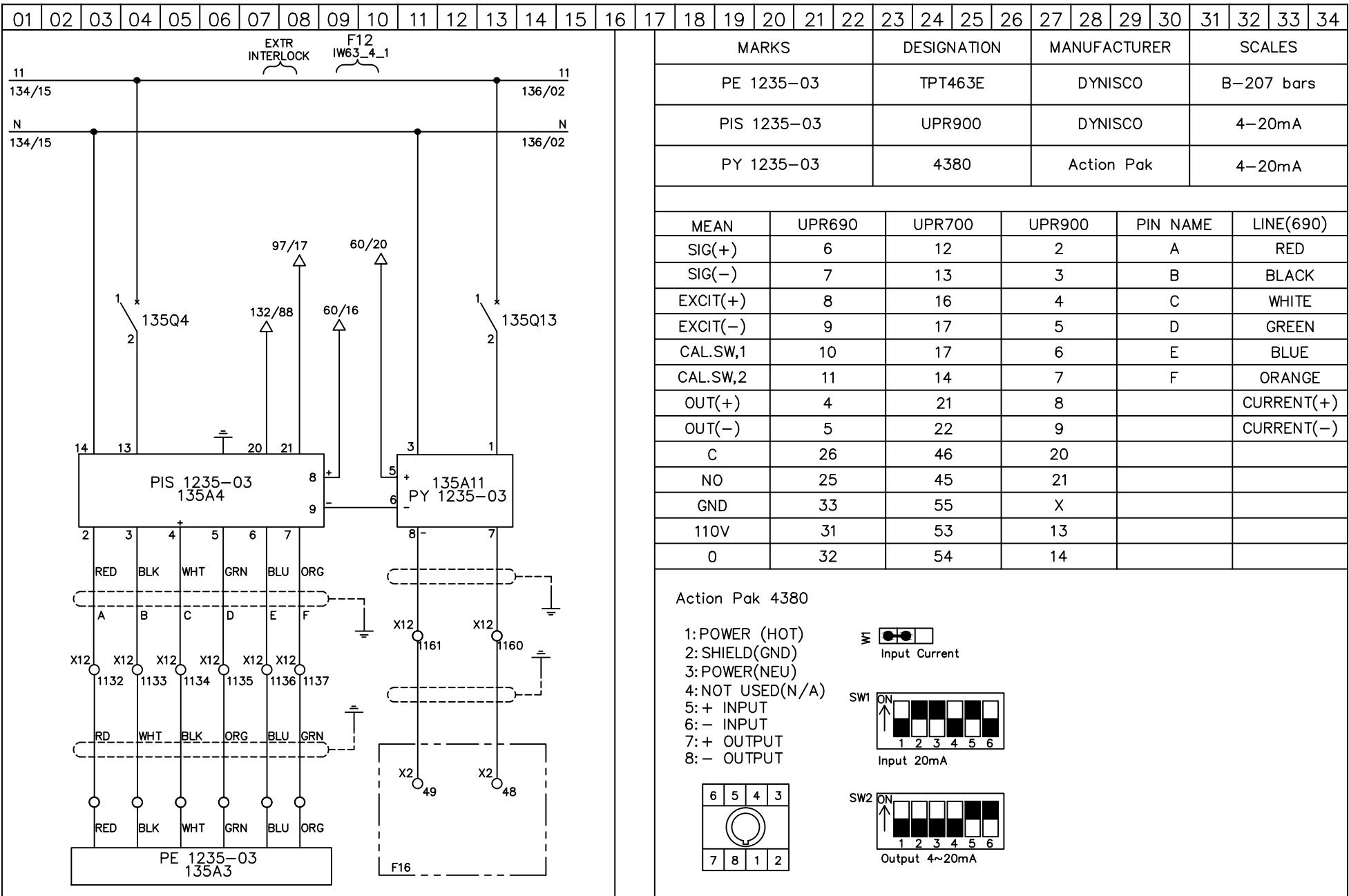
SW2

ON						
↑	1	2	3	4	5	6
	Output	4~20mA				

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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.		Line4 MELT PRESSURE BEFORE DIE PE 1250-03 (P516, 0-3000PSI)																DRAWING DESCRIPTION	<u>KF023</u>		Page #		133									
DRAWN BY	Charlie Zhang																		DRAWING NO.			Total											
CHECKED BY	VINCENT HUANG																		REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	10/15/2018		SCALE	NONE	UNIT	MM				

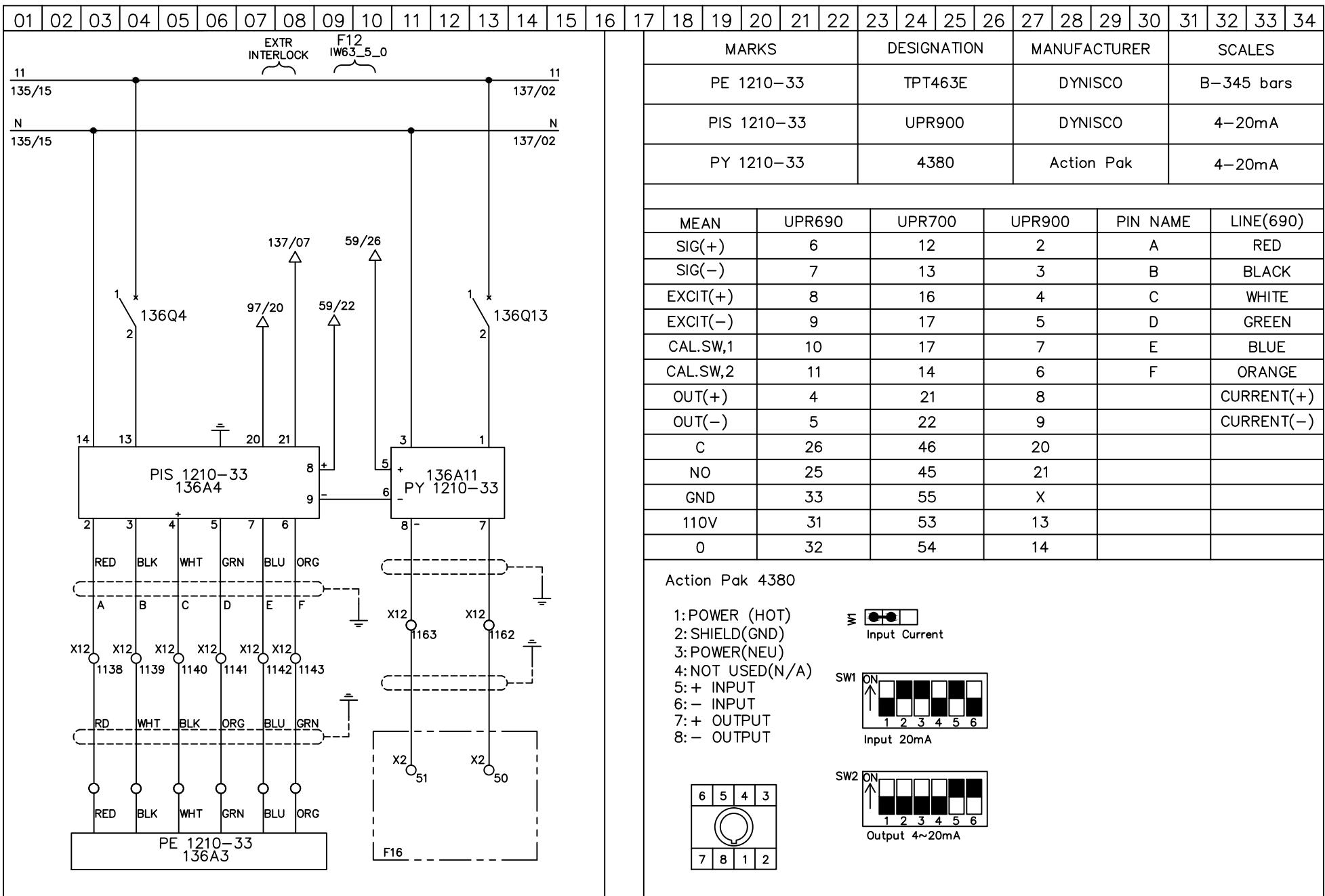


01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34			
	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.								Line4 MELT PRESSURE AFTER SAT.1 PE 1210-31 (P501, 0-5000PSI)								DRAWING DESCRIPTION		KF023		Page #		134													
DRAWN BY	Charlie Zhang																DRAWING NO.		Total																	
CHECKED BY	VINCENT HUANG																REV. NO.		REV. DESCRIPTION		REV. BY:		REV. DATE:		DRAWN DATE:		10/15/2018		SCALE		NONE		UNIT		MM	



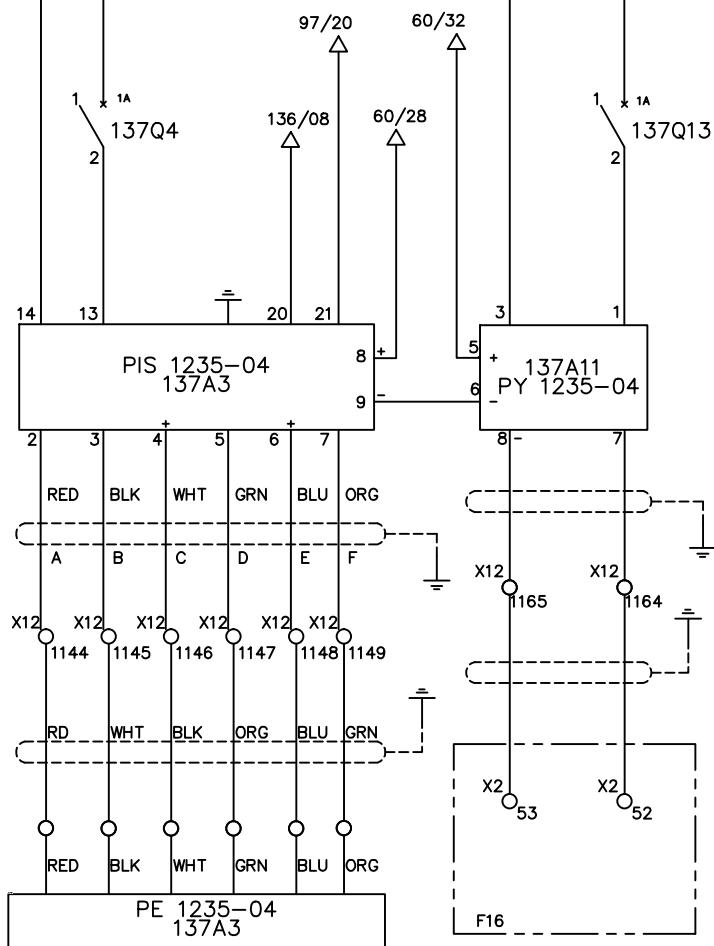
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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.												DRAWING DESCRIPTION				KF023				Page #				135								
DRAWN BY	Charlie Zhang																												Total				
CHECKED BY	VINCENT HUANG												DRAWING NO.								MATERIAL												
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	10/15/2018				SCALE	NONE	UNIT	MM																					

Line4 MELT PRESSURE BEFORE DIE
 PE 1235-03 (P503, 0-3000PSI)



01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.														Line4 MELT PRESSURE AFTER SAT.2 PE 1210-33 (P505, 0-5000PSI)																		
DRAWN BY	Charlie Zhang														DRAWING DESCRIPTION																		
CHECKED BY	VINCENT HUANG														DRAWING NO.																		
															REV. NO. REV. DESCRIPTION REV. BY: REV. DATE DRAWN DATE: 10/15/2018																		
															SCALE NONE UNIT MM																		
															Page # 136																		
															Total																		

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11 136/15								F12 IW63_6_1								PE 1235-04 TPT463E DYNISCO B-207 bars																																																																																											
N 136/15								140/02								PIS 1235-04 UPR900 DYNISCO 4-20mA																																																																																											
								PY 1235-04 4380 Action Pak 4-20mA																																																																																																			
																<table border="1"> <thead> <tr> <th>MEAN</th><th>UPR690</th><th>UPR700</th><th>UPR900</th><th>PIN NAME</th><th>LINE(690)</th></tr> </thead> <tbody> <tr><td>SIG(+)</td><td>6</td><td>12</td><td>2</td><td>A</td><td>RED</td></tr> <tr><td>SIG(-)</td><td>7</td><td>13</td><td>3</td><td>B</td><td>BLACK</td></tr> <tr><td>EXCIT(+)</td><td>8</td><td>16</td><td>4</td><td>C</td><td>WHITE</td></tr> <tr><td>EXCIT(-)</td><td>9</td><td>17</td><td>5</td><td>D</td><td>GREEN</td></tr> <tr><td>CAL.SW,1</td><td>10</td><td>17</td><td>6</td><td>E</td><td>BLUE</td></tr> <tr><td>CAL.SW,2</td><td>11</td><td>14</td><td>7</td><td>F</td><td>ORANGE</td></tr> <tr><td>OUT(+)</td><td>4</td><td>21</td><td>8</td><td></td><td>CURRENT(+)</td></tr> <tr><td>OUT(-)</td><td>5</td><td>22</td><td>9</td><td></td><td>CURRENT(-)</td></tr> <tr><td>C</td><td>26</td><td>46</td><td>20</td><td></td><td></td></tr> <tr><td>NO</td><td>25</td><td>45</td><td>21</td><td></td><td></td></tr> <tr><td>GND</td><td>33</td><td>55</td><td>X</td><td></td><td></td></tr> <tr><td>110V</td><td>31</td><td>53</td><td>13</td><td></td><td></td></tr> <tr><td>0</td><td>32</td><td>54</td><td>14</td><td></td><td></td></tr> </tbody> </table>								MEAN	UPR690	UPR700	UPR900	PIN NAME	LINE(690)	SIG(+)	6	12	2	A	RED	SIG(-)	7	13	3	B	BLACK	EXCIT(+)	8	16	4	C	WHITE	EXCIT(-)	9	17	5	D	GREEN	CAL.SW,1	10	17	6	E	BLUE	CAL.SW,2	11	14	7	F	ORANGE	OUT(+)	4	21	8		CURRENT(+)	OUT(-)	5	22	9		CURRENT(-)	C	26	46	20			NO	25	45	21			GND	33	55	X			110V	31	53	13			0	32	54	14		
MEAN	UPR690	UPR700	UPR900	PIN NAME	LINE(690)																																																																																																						
SIG(+)	6	12	2	A	RED																																																																																																						
SIG(-)	7	13	3	B	BLACK																																																																																																						
EXCIT(+)	8	16	4	C	WHITE																																																																																																						
EXCIT(-)	9	17	5	D	GREEN																																																																																																						
CAL.SW,1	10	17	6	E	BLUE																																																																																																						
CAL.SW,2	11	14	7	F	ORANGE																																																																																																						
OUT(+)	4	21	8		CURRENT(+)																																																																																																						
OUT(-)	5	22	9		CURRENT(-)																																																																																																						
C	26	46	20																																																																																																								
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110V	31	53	13																																																																																																								
0	32	54	14																																																																																																								
																<p>Action Pak 4380</p> <table border="1"> <tr><td>1: POWER (HOT)</td></tr> <tr><td>2: SHIELD(GND)</td></tr> <tr><td>3: POWER(NEU)</td></tr> <tr><td>4: NOT USED(N/A)</td></tr> <tr><td>5: + INPUT</td></tr> <tr><td>6: - INPUT</td></tr> <tr><td>7: + OUTPUT</td></tr> <tr><td>8: - OUTPUT</td></tr> </table>								1: POWER (HOT)	2: SHIELD(GND)	3: POWER(NEU)	4: NOT USED(N/A)	5: + INPUT	6: - INPUT	7: + OUTPUT	8: - OUTPUT																																																																												
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7: + OUTPUT																																																																																																											
8: - OUTPUT																																																																																																											
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																<p>Input 20mA</p>																																																																																											
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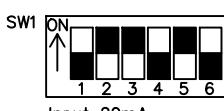


Action Pak 4380

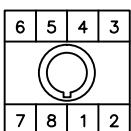
- 1:POWER (HOT)
2:SHIELD(GND)
3:POWER(NEU)
4:NOT USED(N/A)
5:+ INPUT
6:- INPUT
7:+ OUTPUT
8:- OUTPUT



ut Current



Input 20m



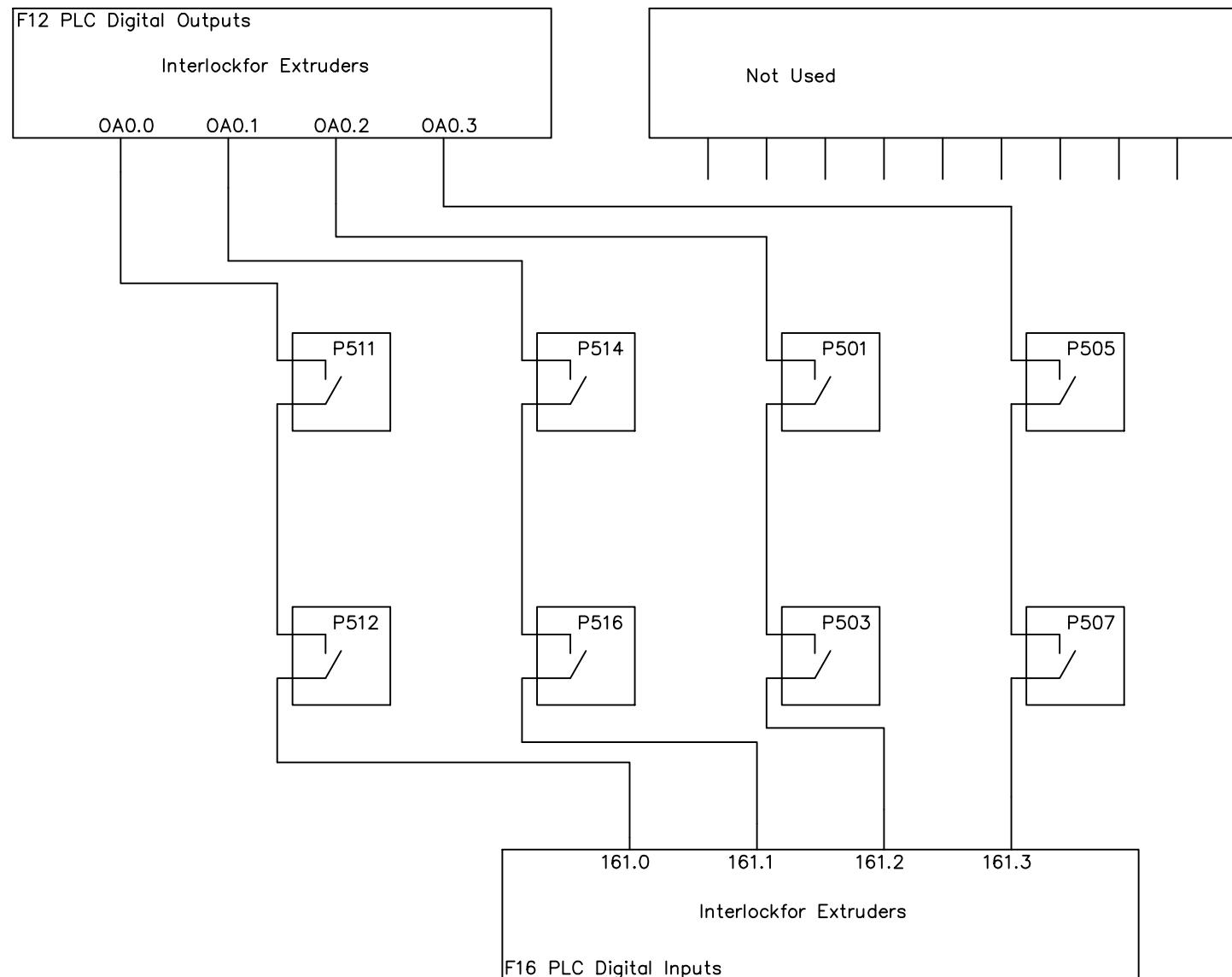
SW2

ON	<input checked="" type="checkbox"/>					
	↑					
	1	2	3	4	5	6

Output 4~20mA

Output 4~20mA

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	INTEPLAST GROUP, Ltd.	AMTOPP DIV. M/E DEPT.																															
DRAWN BY	Charlie Zhang																																
CHECKED BY	VINCENT HUANG																																

Line4 FREE

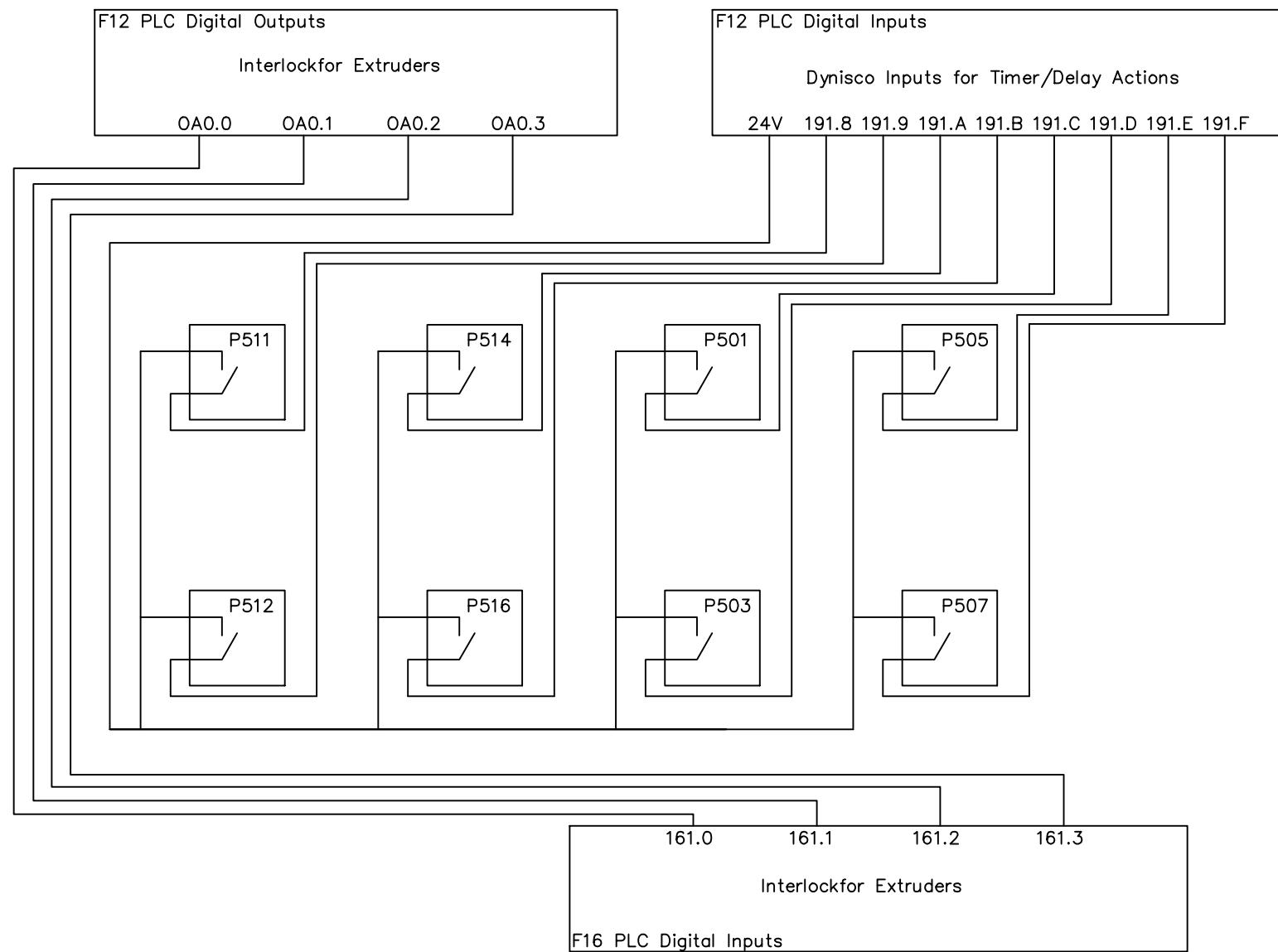
DRAWING DESCRIPTION KF023 Page # 138

Total

MATERIAL

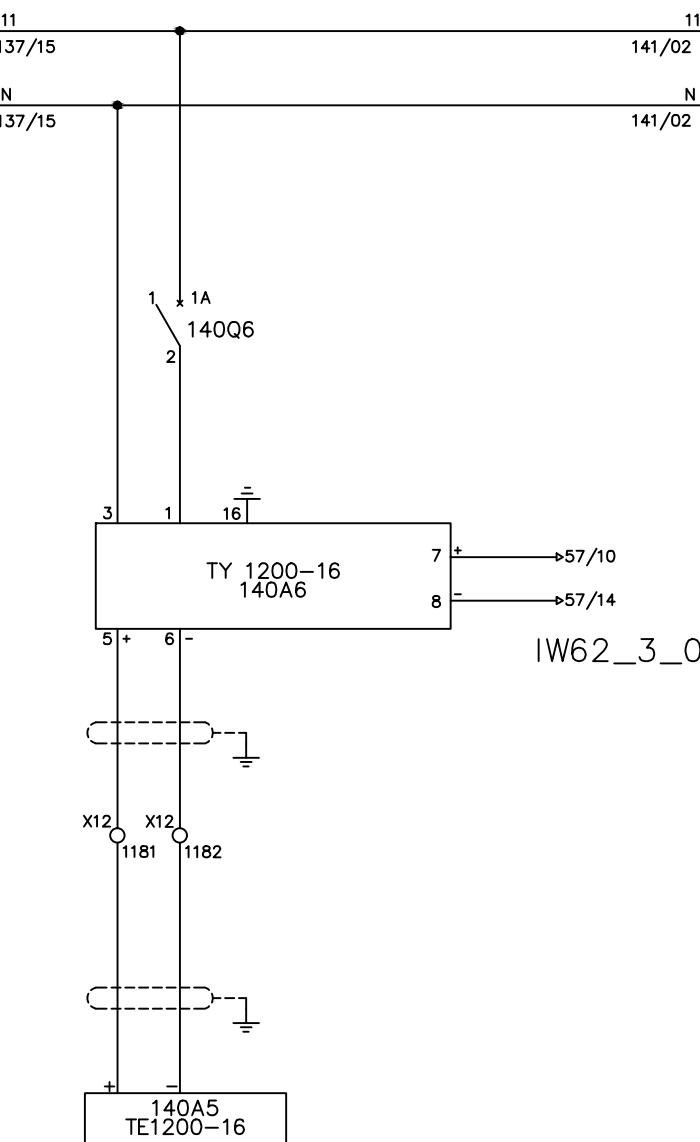
REV. NO REV. DESCRIPTION REV. BY: REV. DATE DRAWN DATE: 10/31/2018 SCALE NONE UNIT MM

01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34



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	INTEPLAST GROUP, Ltd.	Line4 FREE	DRAWING DESCRIPTION	KF023	Page #	139																											
	ANTOPP DIVI. M/E DEPT.				Total																												
DRAWN BY	Charlie Zhang		DRAWING NO.		MATERIAL																												
CHECKED BY	VINCENT HUANG	REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	10/31/2018	SCALE	NONE	UNIT	MM																						

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MARKS	DESIGNATION	MANUFACTURER	SCALES
TE -1200-16	TPT 463E	DYNISCO	TYPE J
TY -1200-16	4351	Action Pak	0-300 C

JUNCTION

TERMINAL + : WIRE YELLOW (IRON)

TERMINAL - : WIRE BLACK (CONSTANATAN)

CONVERTER

INPUT 0-300 deg.C TYPE J

OUTPUT 4-20 mA

TERMINALS BLOCKS BETWEEN PROBE AND CONVERTER TO COMPENSATE THERMOCOUPLE J

01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 MELT TEMP . AFTER PRIMARY
EXT.1 TE1200-16 (T510)

DRAWN BY Charlie Zhang

CHECKED BY VINCENT HUANG

					DRAWING DESCRIPTION	KF012	Page #	140	
							Total		
					DRAWING NO.		MATERIAL		
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	10/15/2018	SCALE	NONE	UNIT	MM

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																MARKS		DESIGNATION		MANUFACTURER		SCALES											
																TE -1200-19		PT 462E		DYNISCO		TYPE J											
																TY -1200-19		4351		Action Pak		0-300 C											
																JUNCTION																	
																TERMINAL + : WIRE YELLOW (IRON)																	
																TERMINAL - : WIRE BLACK (CONSTANATAN)																	
																CONVERTER																	
																INPUT 0-300 deg.C TYPE J																	
																OUTPUT 4-20 mA																	
																TERMINALS BLOCKS BETWEEN PROBE AND CONVERTER TO COMPENSATE THERMOCOUPLE J																	

JUNCTION

TERMINAL + : WIRE YELLOW (IRON)

TERMINAL - : WIRE BLACK (CONSTANATAN)

CONVERTER

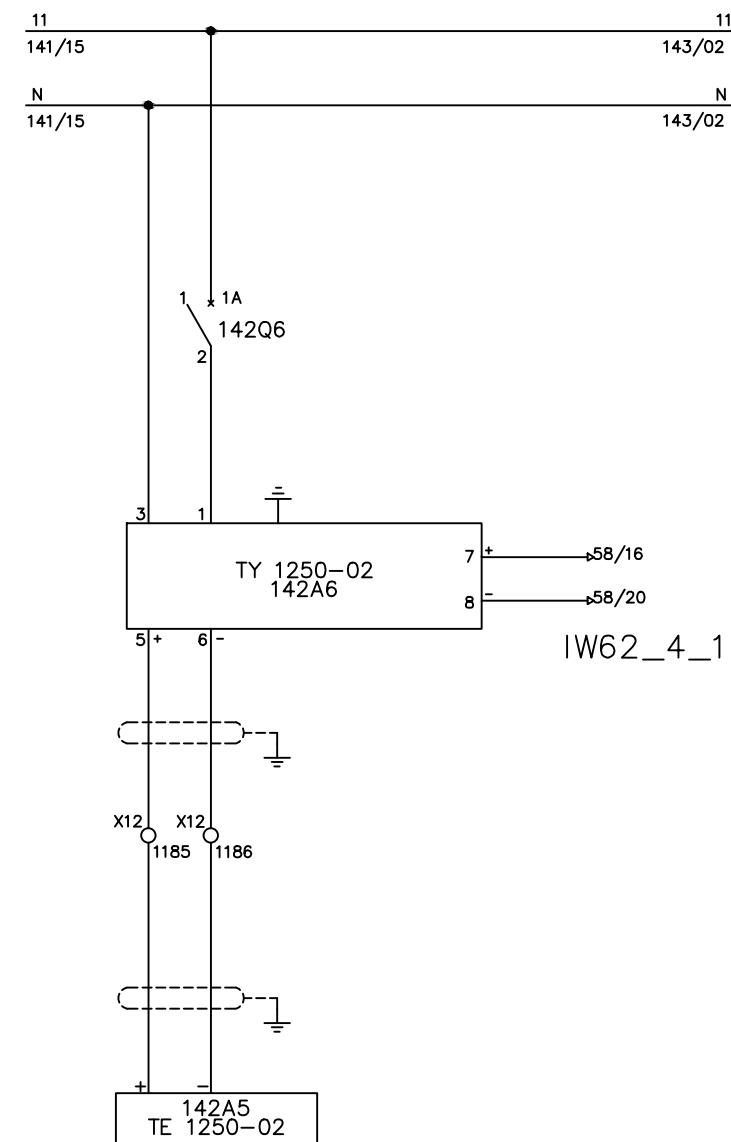
INPUT 0-300 deg.C TYPE J

OUTPUT 4–20 mA

TERMINALS BLOCKS BETWEEN PROBE AND CONVERTER TO COMPENSATE THERMOCOUPLE J

01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.		Line4 MELT TEMP . AFTER SEC.EXT. TE1200-19 (T513)														DRAWING DESCRIPTION	<u>KF012</u>		Page #		141											
DRAWN BY		Charlie Zhang															DRAWING NO.		Total														
CHECKED BY		VINCENT HUANG										REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	10/15/2018		SCALE	NONE	UNIT	MM											

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MARKS	DESIGNATION	MANUFACTURER	SCALES
TE -1250-02	TPT 463E	DYNISCO	TYPE J
TY -1250-02	4351	Action Pak	0-300 C

JUNCTION

TERMINAL + : WIRE YELLOW (IRON)

TERMINAL - : WIRE BLACK (CONSTANATAN)

CONVERTER

INPUT 0-300 deg.C TYPE J

OUTPUT 4-20 mA

TERMINALS BLOCKS BETWEEN PROBE AND CONVERTER TO COMPENSATE THERMOCOUPLE J

01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 MELT TEMP . BEFORE DIE
TE1250-02 (T515)

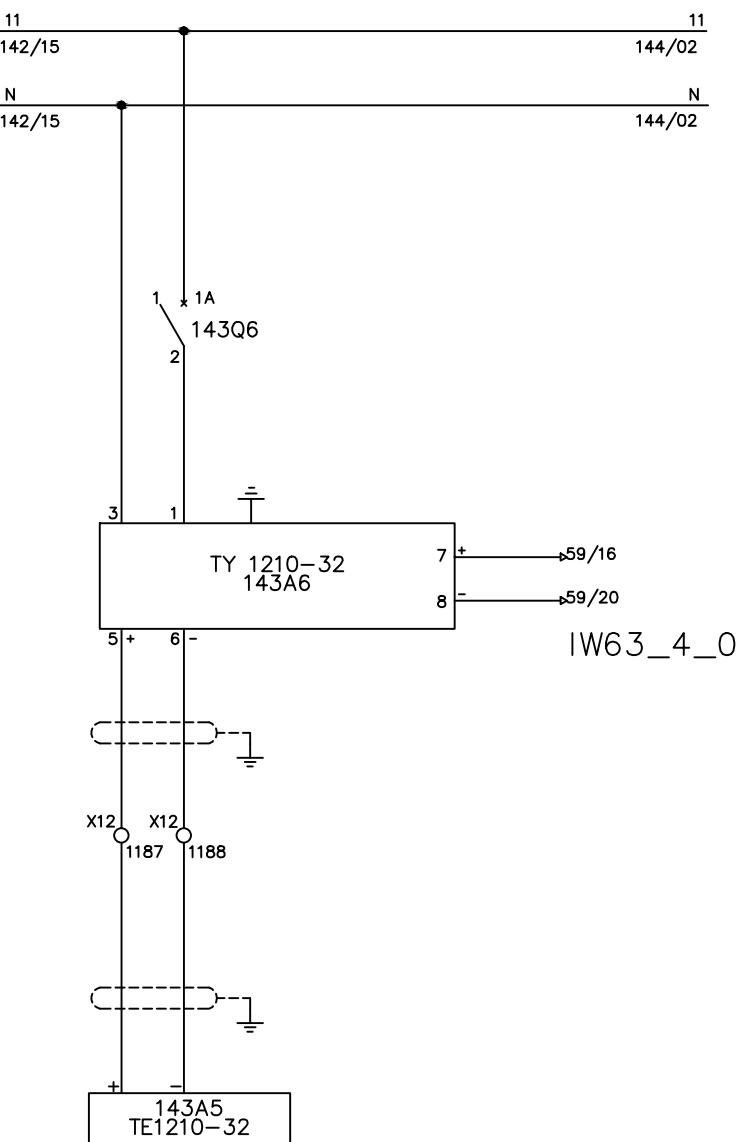
DRAWN BY Charlie Zhang

CHECKED BY VINCENT HUANG

DRAWING DESCRIPTION KF012 Page # 142
DRAWING NO. Total MATERIAL

REV. NO REV. DESCRIPTION REV. BY: REV. DATE DRAWN DATE: 10/15/2018 SCALE NONE UNIT MM

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MARKS	DESIGNATION	MANUFACTURER	SCALES
TE -1210-32	TPT 463E	DYNISCO	TYPE J
TY -1210-32	4351	Action Pak	0-300 C

JUNCTION

TERMINAL + : WIRE YELLOW (IRON)

TERMINAL - : WIRE BLACK (CONSTANATAN)

CONVERTER

INPUT 0-300 deg.C TYPE J

OUTPUT 4-20 mA

TERMINALS BLOCKS BETWEEN PROBE AND CONVERTER TO COMPENSATE THERMOCOUPLE J

01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

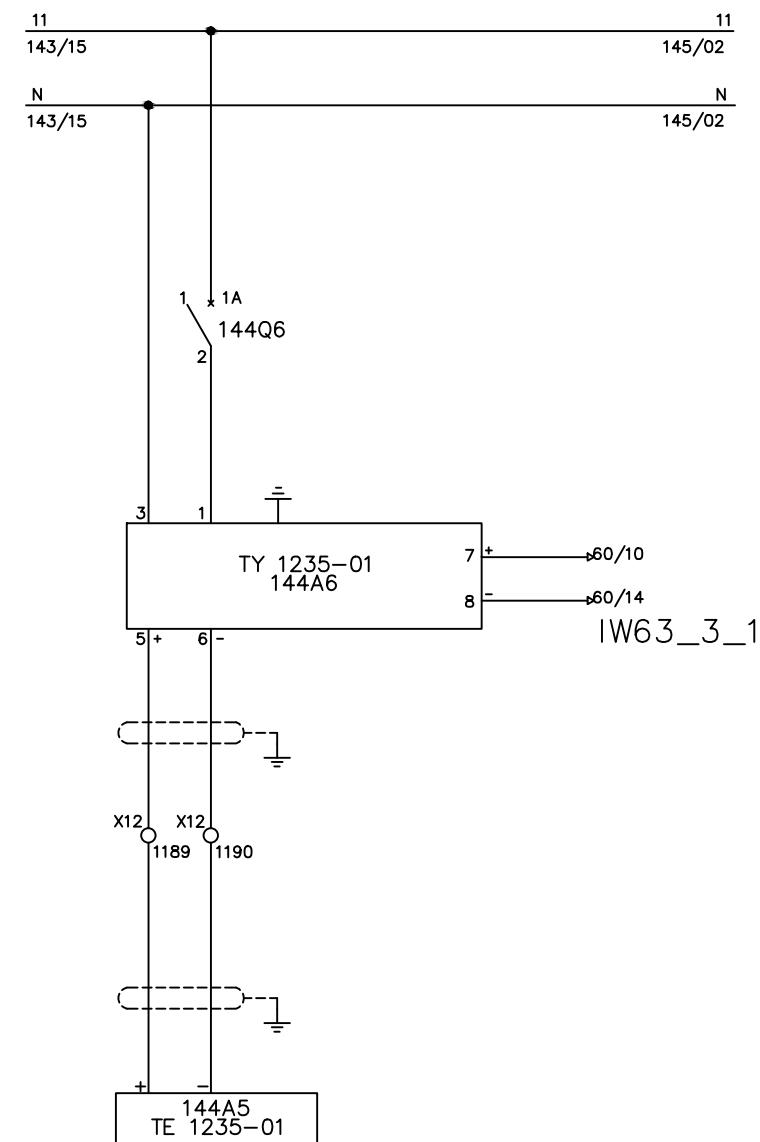
Line4 MELT TEMP . AFTER SAT . EXT
.1 TE1210-32 (T500)

DRAWN BY Charlie Zhang

CHECKED BY VINCENT HUANG

DRAWING DESCRIPTION	KF012	Page #	
		Total	MATERIAL
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DRAWN DATE:	10/15/2018	SCALE	NONE

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MARKS	DESIGNATION	MANUFACTURER	SCALES
TE -1235-01	TPT463E	GULTON	TYPE J
TY -1235-01	4351	Action Pak	0-300 C

JUNCTION

TERMINAL + : WIRE YELLOW (IRON)

TERMINAL - : WIRE BLACK (CONSTANATAN)

CONVERTER

INPUT 0-300 deg.C TYPE J

OUTPUT 4-20 mA

TERMINALS BLOCKS BETWEEN PROBE AND CONVERTER TO COMPENSATE THERMOCOUPLE J

01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
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INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

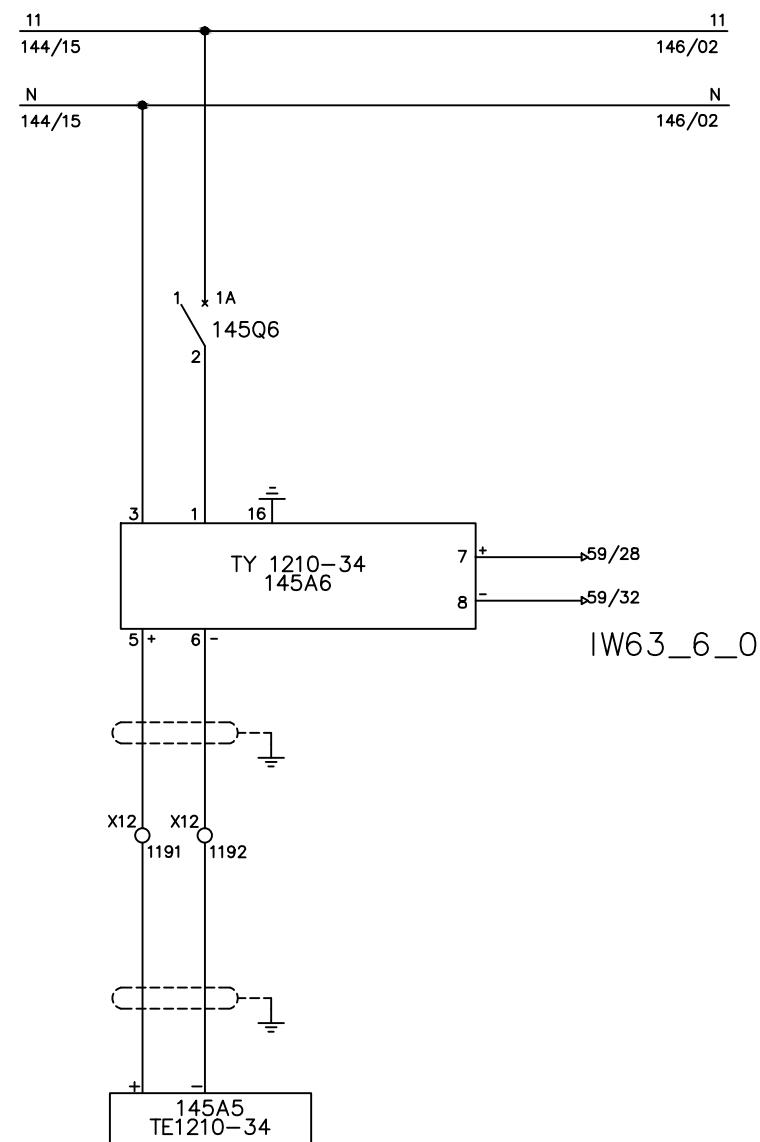
Line4 MELT TEMPERATURE BEFORE DIE
TE1235-01 (T502)

DRAWN BY Charlie Zhang

CHECKED BY VINCENT HUANG

					DRAWING DESCRIPTION	KF012	Page #	144	
							Total		
					DRAWING NO.		MATERIAL		
REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	10/15/2018	SCALE	NONE	UNIT	MM

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MARKS	DESIGNATION	MANUFACTURER	SCALES
TE -1210-34	TPT 463E	DYNISCO	TYPE J
TY -1210-34	4351	Action Pak	0-300 C

JUNCTION

TERMINAL + : WIRE YELLOW (IRON)

TERMINAL - : WIRE BLACK (CONSTANATAN)

CONVERTER

INPUT 0-300 deg.C TYPE J

OUTPUT 4-20 mA

TERMINALS BLOCKS BETWEEN PROBE AND CONVERTER TO COMPENSATE THERMOCOUPLE J

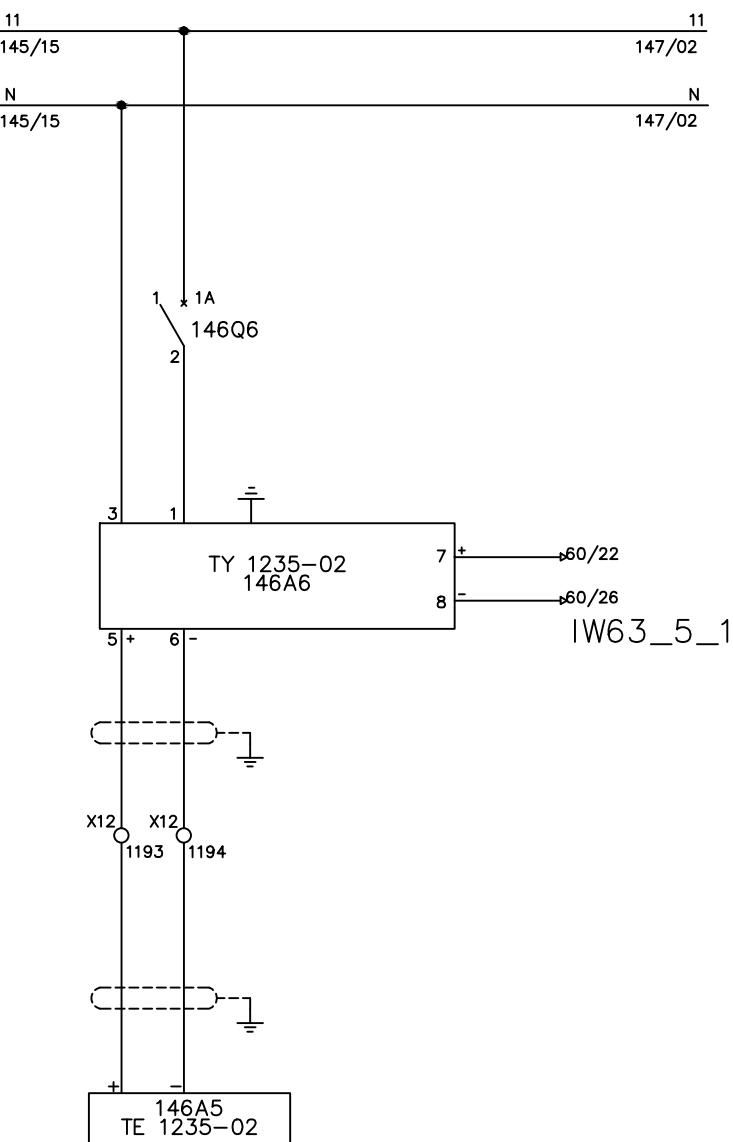
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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.	Line4 MELT TEMP . AFTER SAT . EXT .				REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWING NO.	DRAWING DESCRIPTION	KF023	Page #	145
DRAWN BY	Charlie Zhang										Total			
CHECKED BY	VINCENT HUANG										MATERIAL			

10/15/2018

SCALE NONE UNIT MM

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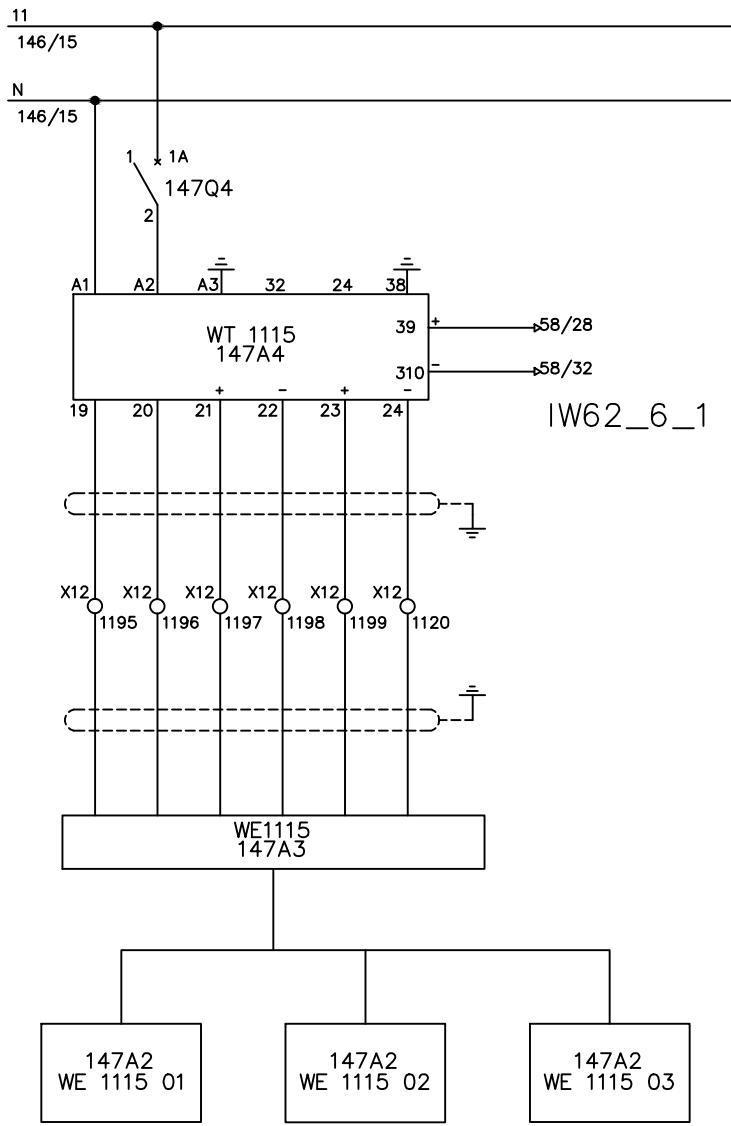


MARKS	DESIGNATION	MANUF ACTURER	SCALES
TE -1235-02	TPT 463E	GULTON	TYPE J
TY -1235-02	4351	Action pak	0-300 C

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	INTEPLAST GROUP, Ltd. AMTOPP DIV. M/E DEPT.	Line4 MELT TEMPERATURE BEFORE DIE										DRAWING DESCRIPTION	KF012	Page #		146								
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DRAWN BY	Charlie Zhang														DRAWING NO.		MATERIAL							
CHECKED BY	VINCENT HUANG														REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	10/15/2018	SCALE	NONE	UNIT	MM

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MARKS	DESIGNATION	MANUFACTURER	SCALES
WE -1115 01	CAP 2500	PESAGE-PROMOTION	0-2500kg
WE -1115 02	CAP 2500	PESAGE-PROMOTION	0-2500kg
WE -1115 03	CAP 2500	PESAGE-PROMOTION	0-2500kg
WE -1115	BR 416	PESAGE-PROMOTION	
WT -1115	TRS 112	PESAGE-PROMOTION	

JUNCTION

TRS 112	BR 416
TERMINAL 19	TERMINAL 24
TERMINAL 20	TERMINAL 24
TERMINAL 21	TERMINAL 25
TERMINAL 22	TERMINAL 25
TERMINAL 23	TERMINAL 22
TERMINAL 24	TERMINAL 23
TERMINAL 25	TERMINAL 21 (SHIELDING)

FOR TRS 112

TAR : Lb
 INPUT : NETT WEIGHT : Lb
 OUTPUT : SIGNAL 4-20 mA

01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
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INTEPLAST GROUP, Ltd.
 AMTOPP DIV. M/E DEPT.

Line4 WEIGHING DEVICE
 WT 1115 (R200)

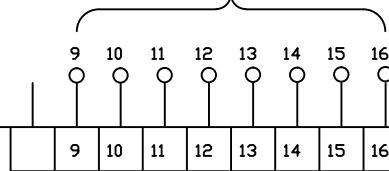
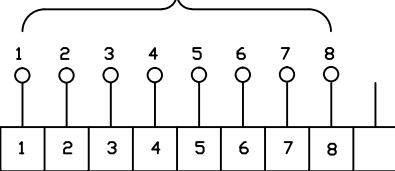
DRAWN BY Charlie Zhang
 CHECKED BY VINCENT HUANG

REV. NO	REV. DESCRIPTION	REV. BY:	REV. DATE	DRAWN DATE:	10/15/2018	SCALE	NONE	UNIT	MM
				DRAWING DESCRIPTION	KF023	Page #	147		
					Total				

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39

FROM RACK 2 / SLOT 11
OA7_0~OA7_7 CH0~CH7 /125

FROM RACK 2 / SLOT 11
OA7_8~OA7_F CH8~CH15 /126

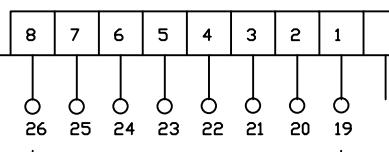
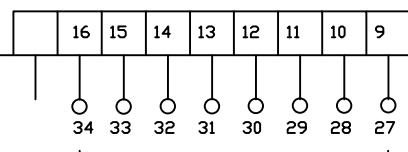


125A10

X12, 12 14 11 22 24 21 32 34 31 42 44 41 52 54 51 62 64 61 72 74 71 82 84 81 92 94 91 102 104 101 112 114 111 122 124 121 132 134 131 142 144 141 152 154 151 162 164 161
978 980 982 984 986 1170 1172 992 994 996 998 1000 1002 1004 1006 1008

X12, 1040 1038 1036 1034 1032 1030 1028 1026 1024 1022 1020 1018 1016 1014 1012 1010
161 164 162 151 154 152 141 144 142 131 134 132 121 124 122 111 114 112 101 104 102 91 94 92 81 82 71 74 72 61 64 62 51 54 52 41 44 42 31 34 32 21 24 22 11 14 12

127A10



FROM RACK 2 / SLOT 11
OB7_7~OB7_F CH8~CH15 /1278

FROM RACK 2 / SLOT 11
OB7_0~OB7_7 CH0~CH7 /127

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



INTEPLAST GROUP, Ltd.
AMTOPP DIV. M/E DEPT.

Line4 DOOR 4 RELAY

KF023
F12

Page #
236

Total

DRAWING NO.

MATERIAL

DRAWN BY Charlie Zhang

CHECKED BY JERRY WU

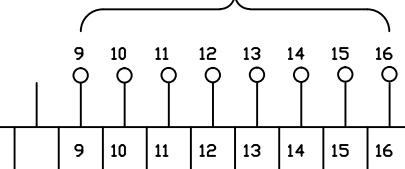
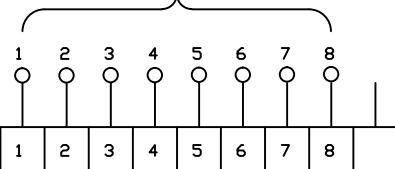
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SCALE NONE UNIT MM

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FROM RACK 2 / SLOT 6
DA2_0~DA2_7 CH0-CH7 /105

FROM RACK 2 / SLOT 6
DA2_8~DA2_F CH8-CH15 /106



105A10

12 14 11 22 24 21 32 34 31 42 44 41 52 54 51 62 64 61 72 74 71 82 84 81 92 94 91 102 104 101 112 114 111 122 124 121 132 134 131 142 144 141 152 154 151 162 164 161
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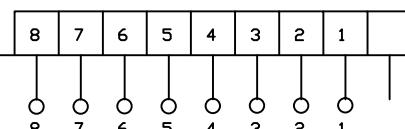
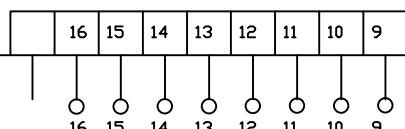
TO X22 FROM TERMINAL 186-217

MAIN LOADING PANEL

MEMO & MENO

116 ?? 113 ?? 41 ?? 42 ?? 32 ?? 115 ?? 20 ?? 21 ?? 31 ?? 7 ?? 23 ?? 12 ??
161 164 162 151 154 152 141 144 142 131 134 132 121 124 122 111 114 112 101 104 102 91 94 92 81 84 82 71 74 72 61 64 62 51 54 52 41 44 42 31 34 32 21 24 22 11 14 12

121A10



00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



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FROM RACK 2 / SLOT 5
DB1_0~DB1_7 CH16-CH23 /103

FROM RACK 2 / SLOT 5
DB1_8~DB1_F CH24-CH31 /104

19 20 21 22 23 24 25 26

27 28 29 30 31 32 33 34

1 2 3 4 5 6 7 8

9 10 11 12 13 14 15 16

103A10

12 14 11 22 24 21 32 34 31 42 44 41 52 54 51 62 64 61 72 74 71 82 84 81 92 94 91 102 104 101 112 114 111 122 124 121 132 134 131 142 144 141 152 154 151 162 164 161

X21 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263

TO X21 FROM TERMINAL 232~263

TO X8

TO X13 FROM TERMINAL 901~904

TO X23 FROM TERMINAL 406~413

167 163 154 150 153 149 152 148 151 56 147 101 104 101 104 413 412 411 410 409 408 407 406

161 164 162 151 154 152 141 144 142 131 134 132 121 124 122 111 114 112 101 104 102 91 94 92 81 84 82 71 74 72 61 64 62 51 54 52 41 44 42 31 34 32 21 24 22 11 14 12

111A10

16 15 14 13 12 11 10 9

8 7 6 5 4 3 2 1

FROM RACK 2 / SLOT 7
DB3_8~DB3_F CH24-CH31 /112

FROM RACK 2 / SLOT 7
DB3_0~DB3_7 CH16-CH23 /111

34 33 32 31 30 29 28 27

26 25 24 23 22 21 20 19

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



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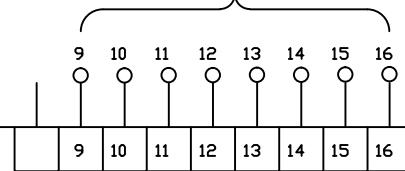
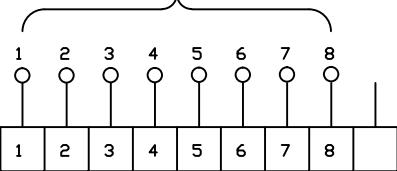
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FROM RACK 2 / SLOT 5
DA1_0~DA1_7 CH0-CH7 /101

FROM RACK 2 / SLOT 5
DA1_8~DA1_F CH8-CH15 /102



101A10

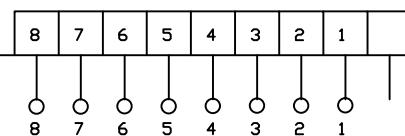
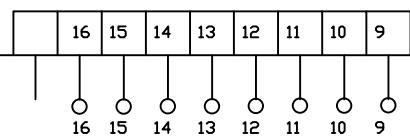
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200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231

TO X21 FROM TERMINAL 200~231

TO X23 FROM TERMINAL 374~405

405 404 403 402 401 400 399 398 397 396 395 394 393 392 391 390 389 388 387 386 385 384 383 382 381 380 379 378 377 376 375 374
161 164 162 151 154 152 141 144 142 131 134 132 121 124 122 111 114 112 101 104 102 91 94 92 81 84 82 71 74 72 61 64 62 51 54 52 41 44 42 31 34 32 21 24 22 11 14 12

109A10



FROM RACK 2 / SLOT 7
DA3_8~DA3_F CH8-CH15 /110

FROM RACK 2 / SLOT 7
DA3_0~DA3_7 CH0-CH7 /109

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



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FROM RACK 2 / SLOT 4
DB0_0~DB0_7 CH16-CH23 /99

FROM RACK 2 / SLOT 4
DB0_8~DB0_F CH24-CH31 /100

19 20 21 22 23 24 25 26

27 28 29 30 31 32 33 34

1 2 3 4 5 6 7 8

9 10 11 12 13 14 15 16

99A10

12 14 11 22 24 21 32 34 31 42 44 41 52 54 51 62 64 61 72 74 71 82 84 81 92 94 91 102 104 101 112 114 111 122 124 121 132 134 131 142 144 141 152 154 151 162 164 161

?? ?? ?? ?? 29 30 35 36 54 55 60 61 4 5 10 11 52 56 53 54 55 108 136 ?? ?? ?? ??

TO X5

TO X8

TO X22 FROM TERMINAL 218 ~ 249

249 248 247 246 245 244 243 242 241 240 239 238 237 236 235 234 233 232 231 230 229 228 227 226 225 224 223 222 221 220 219 218
161 164 162 151 154 152 141 144 142 131 134 132 121 124 122 111 114 112 101 104 102 91 94 92 81 84 82 71 74 72 61 64 62 51 54 52 41 44 42 31 34 32 21 24 22 11 14 12

107A10

16 15 14 13 12 11 10 9

8 7 6 5 4 3 2 1

FROM RACK 2 / SLOT 6
DB2_8~DB2_F CH24-CH31 /108

FROM RACK 2 / SLOT 6
DB2_0~DB2_7 CH16-CH23 /107

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39



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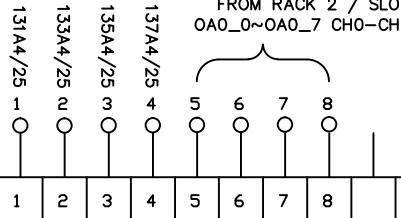
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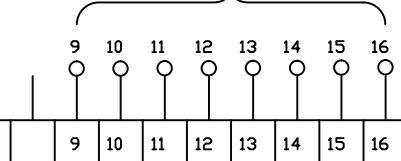
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FROM RACK 2 / SLOT 4
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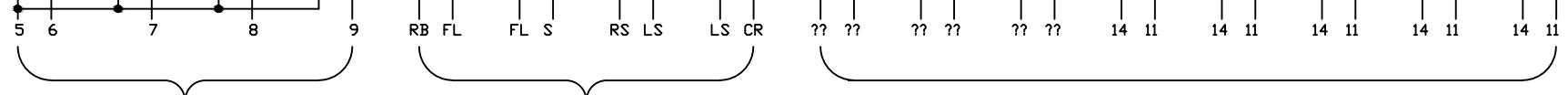


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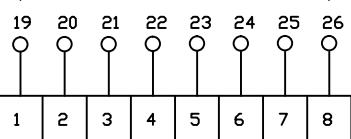


97A10

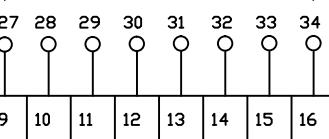
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FROM RACK 2 / SLOT 10
OB6_0~OB6_7 CH16-CH23 /123



FROM RACK 2 / SLOT 10
OB6_8~OB6_F CH24-CH31 /124



123A10

12 14 11 22 24 21 32 34 31 42 44 41 52 54 51 62 64 61 72 74 71 82 84 81 92 94 91 102 104 101 112 114 111 122 124 121 132 134 131 142 144 141 152 154 151 162 164 161

MEMO & MEND

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